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U. S. NAVAL PROVING GROUND DAHLGREN, VIRGINIA

REPORT NO. 1161

TESTS OF SLOTTED TUBE CATAPULTS

8th Partial Report

XC MARK ! CATAPULT-HYDROGEN PEROXIDE TESTS

FINAL Report

Task

Assignment NPG-Re5a-37-1-53

Copy No. 11

Classification CONFIDENTIAL,

SECURITY INFORMATION

PART A

SYNOPSIS

1. The effect of injecting hydrogen peroxide solutions into the chamber of a catapult during burning of the propellant was investigated experimentally in a large-volume closed bomb. Solutions of hydrogen peroxide in water, in concentrations varying from zero to 60 per cent, were tested and oscillograms of pressure and thermocouple temperatures versus time were obtained. Large scale graphs of pressure-time histories for individual rounds are reproduced for detailed study and reference.

2. It is concluded that:

- a. Hydrogen peroxide solutions, injected during burning of conventional propellants, exhibit properties both as a propellant and as a coolant to a significant degree. Under closed chamber conditions, a quantity of solution equal in weight to one-half the charge weight can be utilized to maintain the peak pressure with a reduction of the order of four per cent in absolute temperature, to nearly double the pressure with an increase in absolute temperature of only ten per cent, or to yield intermediate effects by adjusting the concentration of the solution between zero and 60 per cent.
- b. A solution concentration of ten per cent is ample for the complete elimination of carbon formation in the chamber.
- c. Consistent operation of an injection system in service will require a positive means of controlling the time of injection and of insuring that the injector is fully discharged. If gas from the main charge is to ignite the auxiliary charge, the size of ignition passages is an important factor in obtaining uniform injection. Under the conditions of these tests, a 3/16" diameter passage proved to be barely adequate.
- d. Synthetic materials used for experimental injector piston seals (Neoprene and Teflon) must be protected from the combined action of hot gases and free oxygen in order to attain satisfactory life. Two relatively simple methods show promise as protective measures: (1) covering the exposed surface with pure aluminum foil, and (2) complete initial submersion of the seal in the liquid.

LUITE ALLAN

XC Mark 1 Catapult-Hydrogen Peroxide Tests

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PART B

INTRODUCTION

AUTHORITY:

The work reported herein was conducted under Task Assignment No. NPG-Re5a-37-1-53 as established by reference (a). Specific authority for the tests is contained in reference (b).

REFERENCES: 2.

- BUORD 1tr Re5a-RMS:djs of 7 August 1952
- BUORD 1tr S83 Ser 38549; Re5a-EOS: cmj of 30 April 1952 NPG Report No. 999 "XC Mk 1 Water Tests" of 14 July 1952
- BUORD Sketch No. 238834-XC Mk 1 Catapult, Test Model Details
- BUORD Sketch No. 329212, XC Mk 1 Catapult Test Model Water Injector Plug

BACKGROUND:

As a means of reducing flame temperatures and secondary explosions in catapults, the injection of water into the chamber during burning has been proposed by the Bureau of Ordnance. The effect of water injection was investigated theoretically by the Atlantic Research Corporation, and in experimental closed bomb tests at the Naval Proving Ground. Injected water was found to cause formation of a heavy residue of carbon in the chamber, and to require an increase in the propellant charge in order to maintain the pressure at the same value as that obtained on firings without injection. As a means of reducing the charge weight and, at the same time preventing carbon formation, it was proposed that water-hydrogen peroxide mixtures be used instead of water alone. By reference (b) the Naval Proving Ground was requested to conduct closed bomb firings to determine the effect of injecting H₂0-H₂0₂ mixtures in concentrations from zero to 60 per cent, with a constant propellant weight and constant weight of injected liquid.

4. OBJECT OF TESTS:

The object of these tests was to investigate the charateristics of H₂O-H₂O₂ injection by firing charges of 16" granulation propellant in a closed chamber, and injecting into the chamber during burning known weights of hydrogen peroxide solution with concentrations of 0, 10, 20, 30, 40, 50 and 60 per cent. Of particular interest was the recording of peak pressures and pressure-time curves during and after firing for all conditions. It was also desired to record such temperature data as could be obtained without delaying the tests. During the course of the experiments, it became necessary also to investigate the design of sealing elements for the injector piston.

5. PERIOD OF TEST:

a.	Date of Project Letter	7 August 1952
b.	Date of Specific Directive	30 April 1952
C.	Date Commenced Test	5 January 1973
đ.	Date Test Completed	8 May 1953

PART C

DETAILS OF TEST

6. DESCRIPTION OF TEST EQUIPMENT:

- a. All rounds were fired in the XC Mk l Catapult test chamber. This chamber was used on prior tests with water injection, reported in reference (c). It is essentially a cylindrical closed bomb with an inside diameter of 9850 and an inside length of 8080. At one end is a breech cap, which is tapped to receive three electric primers, equally spaced on a 6" diameter circle, one dynamic pressure gage, one probe type thermocouple, and one bleeder plug. At the other end is a closing cap. Appendix (A), Figure 1 is a diagram of the test arrangement. Reference (d) is a detail of the chamber.
- b. The water injector is a steel tube 33" long, with an inside diameter of 3" and an outside diameter of 4", and is fitted with a brass piston which divides it into two compartments. The compartment behind the piston, designed to contain an auxiliary charge of powder which yields the pressure required for injection, is pierced with two holes which provide for ignition of this charge. The chamber in front of the piston is designed to contain a quantity of liquid, and terminates in a spray head pierced by ninety-six 1/16" diameter holes which are arranged to spray the liquid upward and forward at an angle of 16° with the horizontal into the catapult chamber. Reference (e) is a detail drawing of the spray head. operation, the injector is loaded with the liquid solution and smokeless powder and placed inside the catapult chamber together with the main chamber charge. The main chamber charge is ignited by means of three Mk 42 electric primers. When the pressure and temperature in the catapult chamber begin to rise, the hot gases pass through the ignition holes in the injector cylinder and ignite the auxiliary charge. This charge forces the piston forward, thereby forcing the hydrogen peroxide solution out through the holes in the spray head, Appendix (A), Figure 2, is a photograph of the spray injector.
- c. The pressure-time and temperature-time records were taken on an electromagnetic recording oscillograph with associated wheatstone bridges and d.c. amplifiers.

d. A probe thermocouple was constructed for comparative temperature measurements. Number 30 iron-constantan thermocouple wire was passed through a hole 00046 diameter on the axis of a stainless steel rod (probe) of 1" length and 00090 diameter and was welded by means of a carbon arc, each wire emerging from the welding bead with no contacts between the welding bead and the asbestos insulation. The welded wires were then pulled back into the 00052 countersink at the top. A seal against gas pressure was obtained by metallic arc using 25-20 stainless steel electrodes. The end of the probe was machined to a diameter of 00175 to facilitate this welding. After welding, the enlarged end was ground to approximately 00090 to increase the speed of response. The probe was not protected during the first three firings (rounds 17, 18 and 19) and was bent to an angle of about 10° in each firing, apparently by the impact of the powder grains. Thereafter, a shield was placed around the probe, which protruded only 1/4", and this prevented the bending observed in previous rounds. Appendix (A), Figures 3, 4 and 5 show the details and photographs of the thermocouple assembly.

8. PROCEDURE:

- a. The main charge to be used in all firings was established at six pounds of 16" master standard powder, index IRIC-14, and the weight of injected liquid at three rounds. Three pounds of liquid represent slightly more than half of the injector capacity. The remaining air space was considered necessary to facilitate filling and sealing by personnel who had no previous experience in handling peroxide. With the experience gained on these firings, it should be possible to utilize up to 90 per cent of the full capacity on future tests.
- b. Five or more rounds were fired at each of 7 different concentrations of liquid, beginning at zero per cent (distilled water) and increasing the H2O2 concentration in increments of ten per cent until a concentration of 60 per cent had been fired. In addition, several rounds were fired without liquid injection for the purpose of comparison. The auxiliary charges used to actuate the injection chamber were composed of from two to six grains (approx. 0.16-0.50 lb.) of the 16" powder. One gram of SR-4990 (pistol powder) was added to each auxiliary charge to aid in ignition. The closing of the firing key, the pressures and the temperatures were recorded with respect to time. Other details of firing procedures are tabulated in Appendix (B), Table I.

- c. Since hydrogen paroxide is corrosive and attacks steel, Fluorolube oil ("S") and Fluorolube heavy grease (Gr544) were used to reduce this corrosive action. Fluorolube oil was used to swab the wall area in front of the piston. Fluorolube heavy grease was used to fill the spray holes in the injector head. These materials have been recommended by the supplier, Buffalo Electro-Chemical Company, Inc., for long time contact with 90 per cent H202. Some corrosive action occurred on the inside chamber of the spray injector, but the corrosion was not severe enough to affect the operation of the device.
- The Neoprene seal used on the injector piston withstood the effects of firing at concentrations of 10 and 20 per cent without significant damage. The same seal failed on the first round in which a 30 per cent concentration was used. A new seal was installed before firing the second round at 30 per cent concentration, and was found, after firing, to be badly deteriorated, charred and cracked. The deterioration was most pronounced, in both cases, at the surface which was above the initial level of the liquid. On round 17 a 1/4" thick Teflon seal was used. After firing, the seal was slightly eroded, indicating that gases had escaped around the edges. There were brown discolorations on the area above the liquid level. On round 18, there were additional brown discolorations and the edges were croded somewhat more. On round 19, about three-fourths of the area of the seal that was originally above the liquid level was eroded and in a concave shape (facing liquid). This seal was unfit for further use. Appendix (A), Figure 6 is a photograph of the conditions of the three seals used on rounds 15-19. New Teflon seals were used on rounds 20 and 21 and were eroded in a similar manner. On round 22, two 1/8" thick Neoprene cup seals facing in opposite directions were used, protected by a stainless steel disc and aluminum foil bolted to the piston, and tucked into the reservoir around the steel disc and Neoprene. The steel disc and aluminum foil were used to protect the Neoprene seals and help dissipate the heat, as well as to form a reservior for the fluorolube grease and oil. No apparent damage occurred to the seals. A Neoprene buffer ring was installed to protect the disc. After firing, the upper half of this ring was missing. On the following round, the buffer ring was made of copper, and this ring functioned satisfactorily for the remainder of the tests. Figure 7 is a photograph of seals used on rounds 20~24.

e. The liquid injector was originally provided with two 1/8" diameter holes adjacent to the auxiliary charge position, for ignition of this charge. A third hole of the same diameter was provided at the bottom of the auxiliary chamber, but was ineffective as an ignition hole because it terminated at the chamber wall. Before beginning these tests, one of the ignition holes was enlarged to 3/16" diameter in an attempt to improve the ignition of the auxiliary charge.

9. RESULTS AND DISCUSSION:

- a. The results of firing tests with liquid injection are tabulated in Appendix (B), Table II. Table III shows comparative results for a group of similar rounds fired without injection.
- b. The effect of H_2O_2 concentration on peak pressure is shown graphically in Appendix (C), Figure 8. Peak pressures of all rounds are plotted as individual points on this graph, and a curve has been faired through the mean values. Reference to Figure \hat{o} , and Tables I and II, shows that the injection of a 3-lb. charge of pure water reduces the peak pressure 10 per cent below that obtained without injection. A 10 per cent solution of H_2O_2 is sufficient to restore the pressure to the value obtained without injection and further increases in H_2O_2 concentration produce proportional increases in the peak pressures. The increment of pressure for each one per cent increase in H_2O_2 concentration is 43 psi.
- The effect of concentration on temperature is shown in Figure 9. Here the mean values of the peak recorded temperatures for each concentration are plotted, together with a vertical line connecting the highest and lowest of the individual readings. Although the trend of the curve is not as well defined as in the case of pressures, a straight line provides a good fit. The injection of pure water reduces the recorded temperature 8 per cent below that obtained without injection, and the addition of H2O2 increases the temperature in increments of 2.9°C for each 1 per cent increase in concentration. It is important to note that the peak temperatures recorded are significant only as a means of comparing the relative heating effects under varying conditions. tively, the temperatures recorded are not those of the combustion products but rather of the thermocouple itself which, because of an inherent time lag, does not reach equilibrium until the gas temperature has dropped below its peak. In the case of closed bomb firings such as these, an analytical method of correcting the thermocouple readings is available, but it has not been applied because the actual readings are equally effective for comparing different rounds fired in the same chamber.

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- d. To facilitate detailed study of the burning characteristics under varying injection conditions, pressure-time and temperature-time curves have been plotted for all rounds individually. Two graphs are provided for each round. The first, using a normal time scale, shows the pressure rise, peak, and early stage of decay, covering an interval of two seconds from closing of the firing key. The second uses a compressed time scale in order to accentuate the shape of the decay curve, and shows the pressure and temperature for an interval of 15 seconds from closing of the firing key. The first set of curves is reproduced in Appendix (C), Figures 10-64, inclusive, and the second set in Appendix (D), Figures 65-120, inclusive.
- e. The formation of a carbon residue, which had been observed on all firings with water injection and to a lesser extent, on firings without injection, was not observed on any of the firings where $\rm H_2O_2$ was used. The liquid which remained in the chamber after injecting $\rm H_2O_2$ was light brown in color, and was readily removed by swabbing and flushing, leaving the metal bright and clean.
- f. Operation of the liquid injector is not positive. Variations in its operation are the most probable cause of round-to-round dispersion in pressures and temperatures. However, the consistency of operation during this series of tests was much improved over that of earlier tests. This was due to two factors: (1) the improved ignition achieved by enlargement of one of the ignition holes from 1/8" to 3/16" diameter, and (2) the use of effective, liquid-tight seals ahead of the spray piston. It was found necessary to increase the auxiliary charge progressively as the concentration of H₂O₂ was increased, to prevent short travel of the piston. Ultimately, the charge was increased to 6 grains of 16" powder (0.5 lb.).
- g. Of the two materials used as experimental seals for the injector piston, Teflon is more resistant to deterioration than Neoprene; however, neither material has a satisfactory life when used without protection. The flexibility of Neoprene made it more adaptable than Teflon to the special protective measures which finally resulted in a satisfactory seal life, as described in paragraph (8-d). The deterioration of the seals was considerably greater in the area above the liquid level than in the area below. In the case of Teflon, deterioration was almost entirely confined to the upper area. This indicates that the damage occurred before injection, and resulted from impingement of gases from the main charge on this area. These gases, having traversed the surface of the liquid, would be rich in oxygen and very active. This suggests another method of increasing the life of seals: tilting the injector so that the sealing element is initially covered by liquid.

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PART D

CONCLUSIONS

- 10. 3. Hydrogen peroxide solutions, injected during burning of conventional propellants, exhibit properties both as a propellant and as a coolant to a significant degree. Under closed chamber conditions, a quantity of solution equal in weight to cne-half the charge weight can be utilized to maintain the peak pressure with a reduction of the order of four per cent in absolute temperature, to nearly double the pressure with an increase in absolute temperature of only ten per cent, or to yield intermediate effects by adjusting the concentration of the solution between zero and 60 per cent.
- b. A solution concentration of 10 per cent is ample for the complete elimination of carbon formation in the chamber.
- c. Consistent operation of an injection system in service will require a positive means of controlling the time of injection and of insuring that the injector is fully discharged. If gas from the main charge is to ignite the auxiliary charge, the size of the ignition passages is an important factor in obtaining uniform injection. Under the conditions of these tests, a 3/16" diameter passage proved to be barely adequate.
- d. Synthetic materials used for experimental injector piston seals (Neoprene and Teflon) must be protected from the combined action of hot gases and free oxygen in order to attain satisfactory life. Two relatively simple methods show promise as protective measures: (1) covering the exposed surface with pure aluminum foil, and (2) complete initial submersion of the scal in the liquid.

PART E

ACKNOWLEDGEMENTS

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NPG REPORT NO. 1161

U. S. NAVAL PROVING GROUND DAHLGREN, VIRGINIA

. Eighth Partial Report

on

Tests of Slotted Tube Catapults

Pinal Report

on

XC Mark 1 Catapult-Hydrogen Peroxide Tests

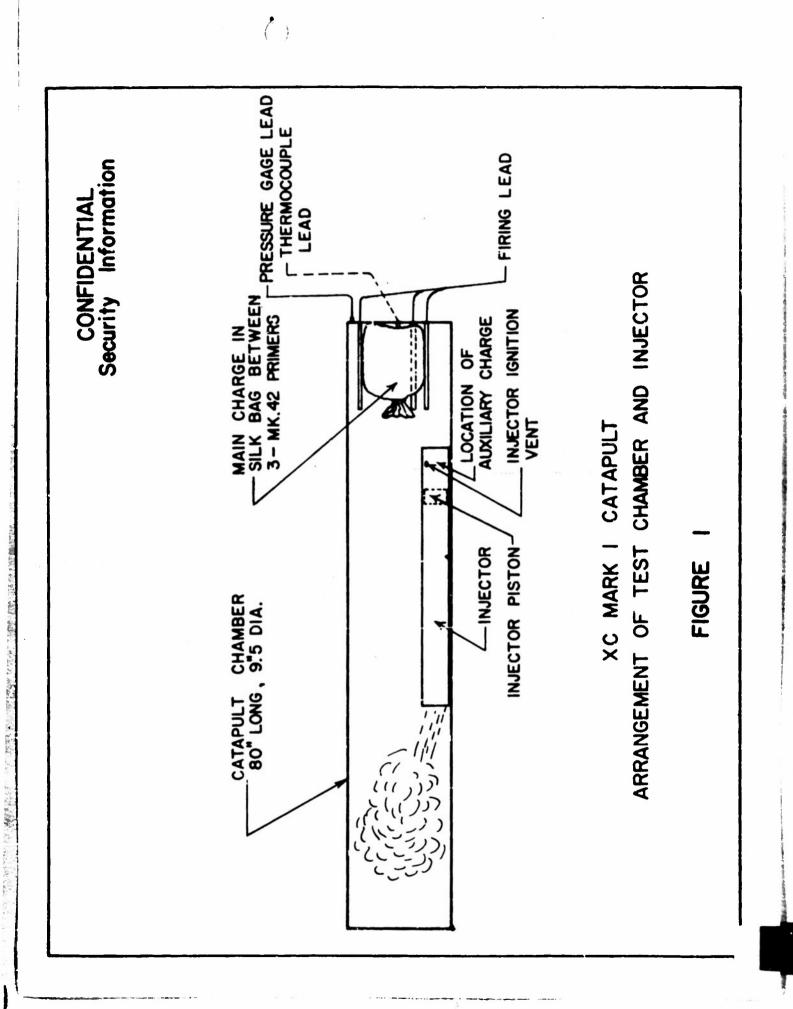
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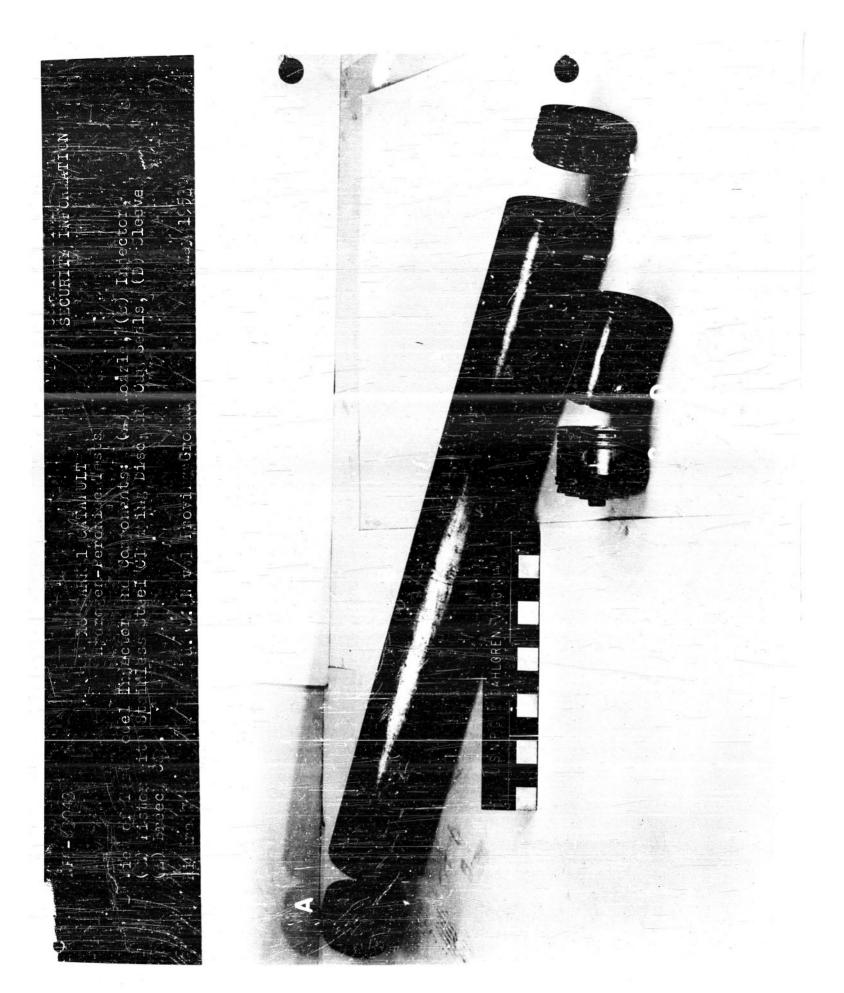
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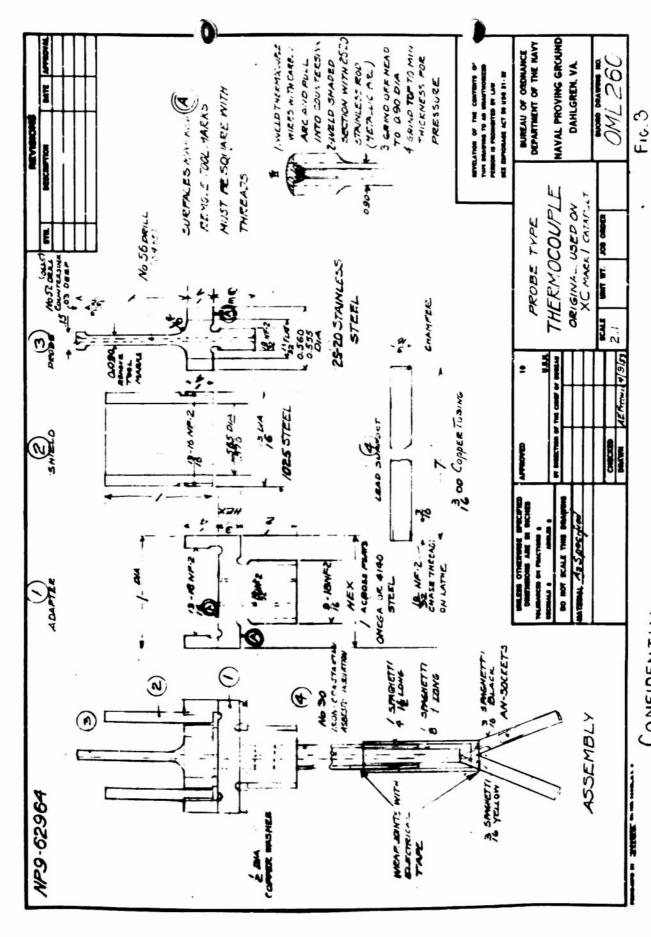
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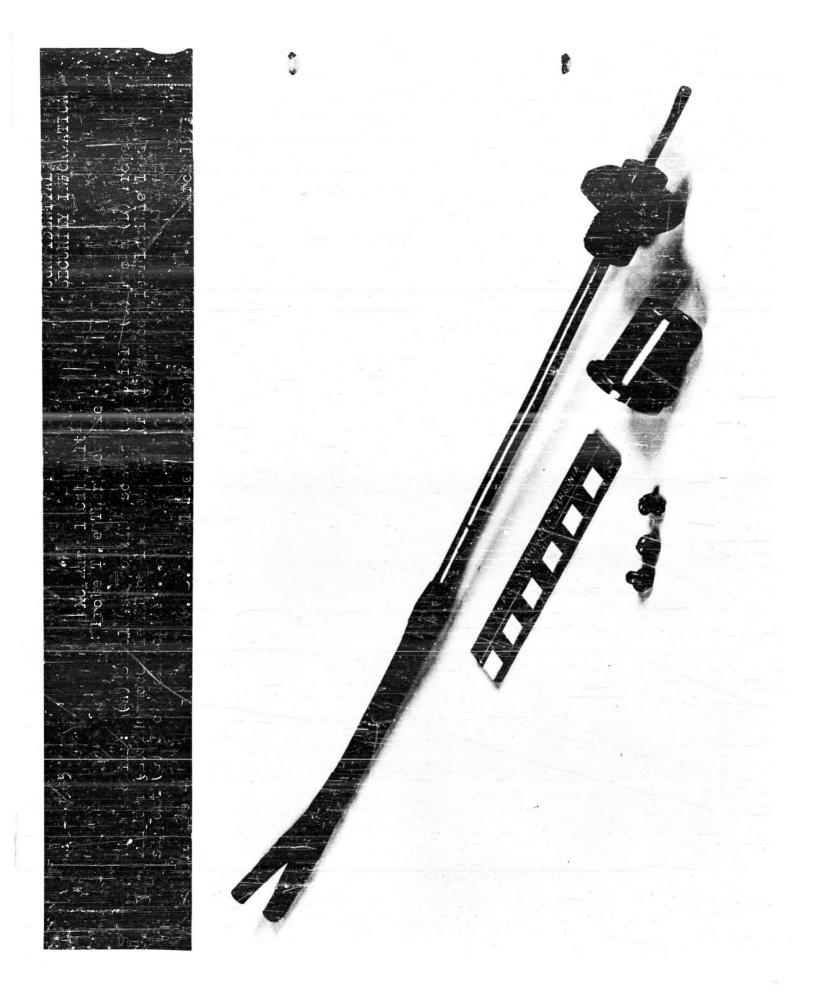
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7 Assembly of shield, probe, adapter and fixed lead support. U. S. Naval Proving Ground XC Mark 1 Catapult Probe Type Thermocouple 1111 DAHLGREN. VIRGINIA 3 INCHES NP9-62966









TABLE I

XC MARK 1 CATAPULT-HYDROGEN PEROXIDE INJECTION CHRONOLOGICAL SUMMARY OF TESTS

Main Charge: 6.0 lb. of 16" Powder, Index IHIC-14
3.0 lb. of solution
Aux. Charge: 16" Powder, Index IHIC-14, as noted.
Ave. weight per grain: 0.083 lb.
Igniter for

Aux. Charge: 1.0 gm. of Pistol Powder SR-4990 Primers: Three, Mark 42.

1953 Date	Round No.	H ₂ 0 ₂ Conc.	Grains Aux. Charge	Travel of Spray Piston	Remarks
1/5	1	0	2		Instrumentation Check- Reduced Charge.
1/6	2	0	2		11 11 11
1/7	2 3 4	0	2	Full	
1/14	4	10	2 2	n	Neoprene seal installed before this round.
1/20	5	10	2	Short (1")	
1/22	6	10	4	Full	
11	5 6 7	10	4	11	Hangfire. Seal damaged by impact and replaced.
1/28	8	10	4	tt .	
n	8	10	4	11	
2/4	1Ó	20	4	Ħ	
2/6	īi	20	4	11	
2/10	12	20	4	11	
2/19	13	20	4	11	
3/6	14	20	4	11	
3/10	15	30	4	Ħ	Seal partially consumed. See Paragraph 8d.
3/11	16	30	4	11	11 11 11
3/13	17	30	4	11	Teflon seal used.
3/16	17 18	30	4	11	
3/17	19	30	4	rr	
3/19	20	40	4	Short (2")	
3/21	21	40	4	11	
3/26	22	40	4	Full	
4/1	23	40	4	Short	
4/3	24	40	. 4	Short	New neoprene seals. See Paragraph 8d.

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XC Mark 1 Catapult-Hydrogen Peroxide Tests

TABLE I (Continued)

1953 Date		H ₂ O ₂ Conc.	Grains Aux. Charge	Travel of Spray Piston	Remarks
4/8 4/10 4/14		50 30 50 50 50 50	5 6	Short Full	
4/15 4/16	27 28 29 30 31 32	50 50 60	556665	• II	Fired to test optical
4/17	33 34	60	5	Full	pyrometer. Fired to test optical pyrometer.
4/20 4/21	35 36 37	60 60	5	Short Full	Fired to test optical pyrometer.
# 4/22 !!	38 39 40	30 60	5 6 -	Full	Fired to test optical pyrometer.
4/23 4/24 4/29 4/30	41 42 43 44 45 46	60 20 20 10 10	655555	Full " " " " " "	pyrome our .
5/1 5/4 5/5 5/7 1 5/8	47.8 49012345678 55555555555	40 40 40 40 40 0 0	655555 166666666666	Full H H H H H H H H H H H H H H H H H H	Pressure not recorded.

TABLE II

XC MARK 1 CATAPULT-HYDROGEN PEROXIDE INJECTION TABULATION OF MAXIMUM PRESSURES AND TEMPERATURE RISE

Weight of Main Charge: 6.0 lb. Weight of Injected Solution: 3.0 lb.

Conc. of Solution	Rd.	Figures	Temp. Rise of Thermo- couple C.	Mean Temp. Rise,	Max. Pres. PSI	Mean Pmax PSI	Remarks
0	3	17,72			3525		Atypical. Injection probably late. Included in mean.
11 11 11 11	54 55 56 57 58	18,74 19,75 20,76 21,77 22,78	735 780 775 785 815	780	2860 2950 2995 3065 3065	3075	Included In medic
10 11 11 11 11 11 11 11 11	4 568 9 44 564 456	23,79 24,80 25,81 26,82 27,83 28,84 29,85 30,86	750	750	3400 3550 3075 3325 3150 3525 3495 3405	3370	
20	10 11 12 13 14 42 43	31,87 32,88 33,89 34,90 35,91 36,92 37,93	775 905	840	3850 4035 3800 4000 3865 4110 4110	3970	

XC Mark 1 Catapult-Hydrogen Peroxide Tests

TABLE II (Continued)

Cone. of Solu- tion	Rd.	Figures	Temp. Rise of Thermo- couple •C.	Mean Temp. Rise,	Max. Pres. PSI	Mean P _{max} PSI	Remarks
30	15 16 17 18 19 26 38	38,94 39,95 40,96 41,97 42,98 43,99 44,100	985 890 930 855 845	900	4080 4475 4575 4475 4310 4600 4510	4440	
40	20 21 22 23 24 48 49 50 51	45,101 46,102 47,103 48,104 49,105 50,106 51,107 52,108 53,109 54,110	835 875 880 880 905 825 895 895 970 925	. 890	4600 4660 4355 4600 4630 4845 5030 5000 5000	4775	
50 11 11	25 27 28 29 30	55,111 56,112 57,113 58,114 59,115	950 885 855 925 905	905	5150 5150 5000 5335 5365	5200	
60	31 33 35 36 39 41	60,116 61,117 62,118 63,119 64,120	1010 1000 895 940 935	955	5920 5645 5335 5800 5950 5610	5700	

TABLE III

XC MARK 1 CATAPULT-DRY ROUNDS TABULATION OF MAXIMUM PRESSURES AND TEMPERATURE RISE

Charge Weight: 6.0 lb., 16"/50 Index IHIC-14

Rd.	Figures	Temp. Rise of Thermo- couple °C	Mean Temp. Rise	Max. Pres. PSI	Mean P _{max} PSI	Remarks	
32	10,65	845	•	3465		Fired to check Pyrometer instrumentation.	•
34 37 40 47	11,66 12,67 13,68 14,69	875 835 845 820	845	3375 3340 3375 3465	3405	Fired to check Ceramic type thermocouple.	

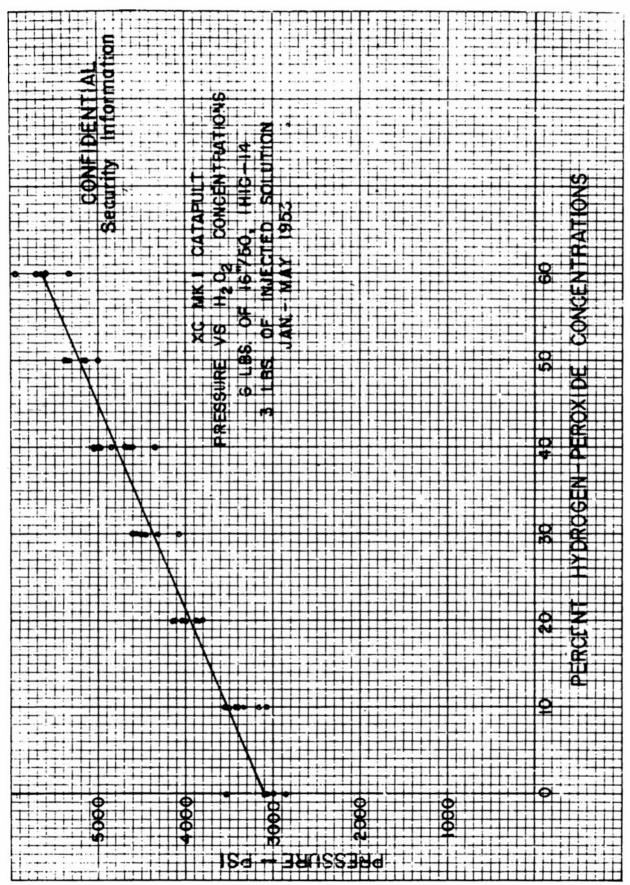


FIGURE 8

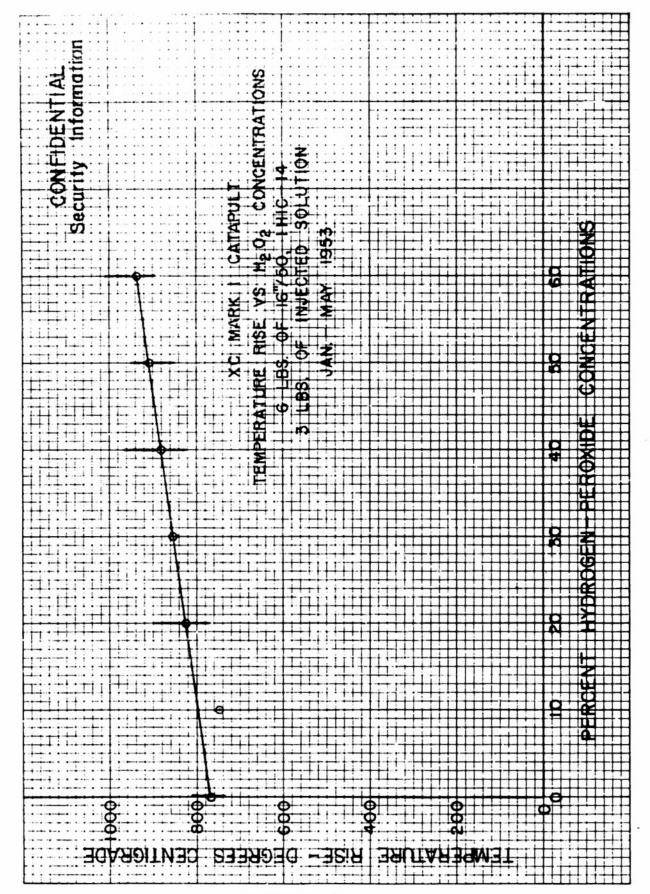
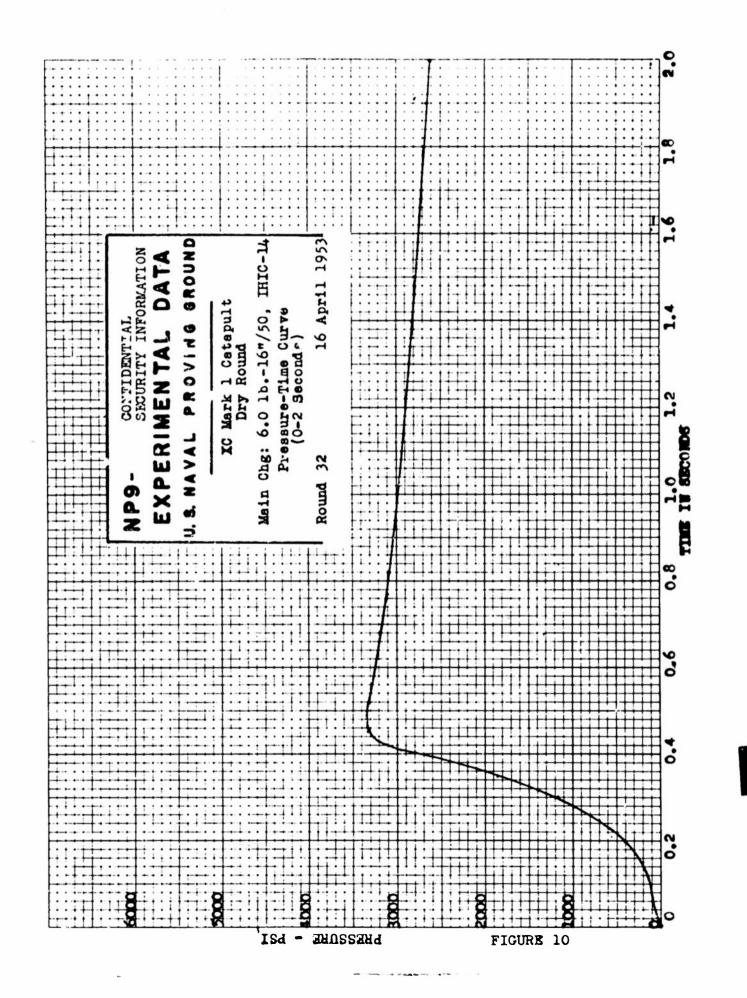
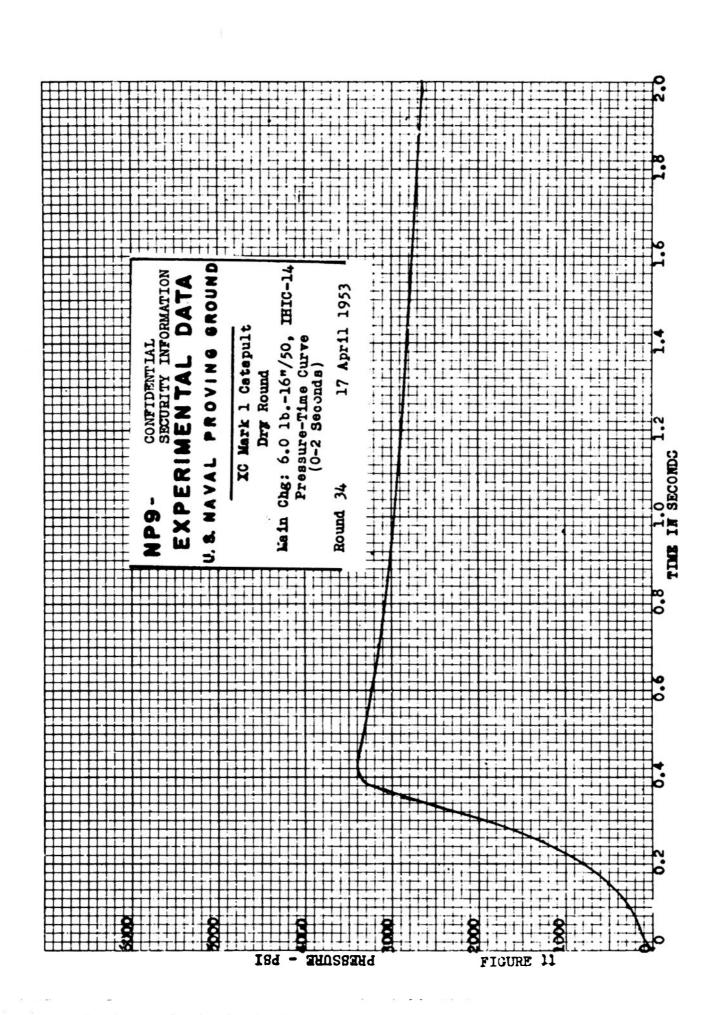
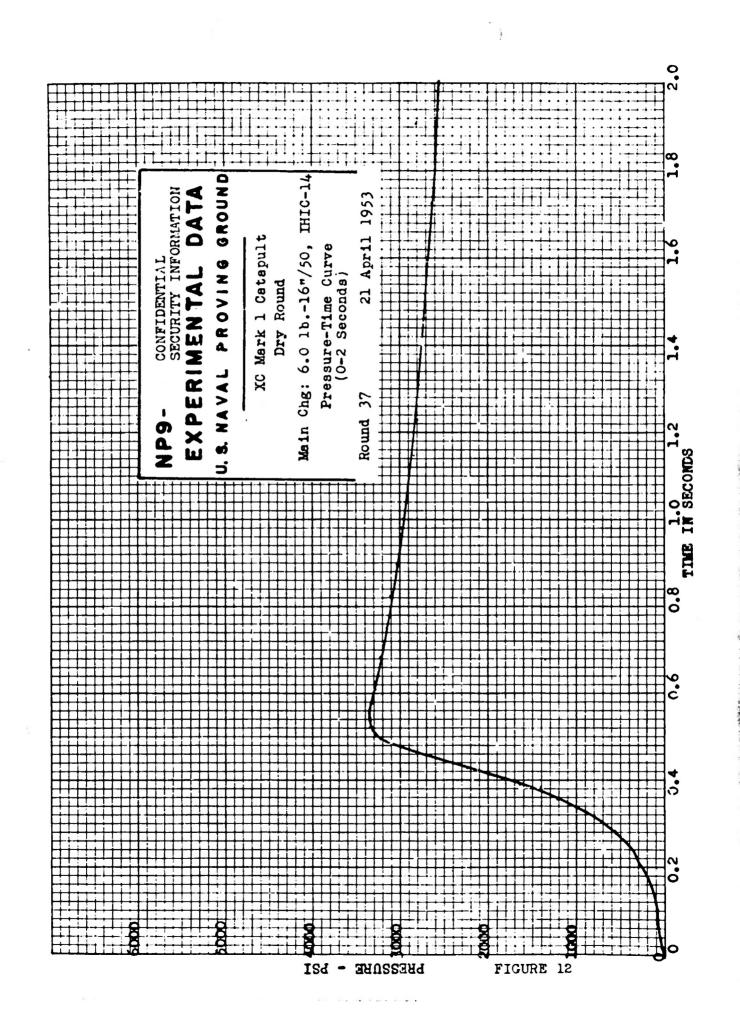
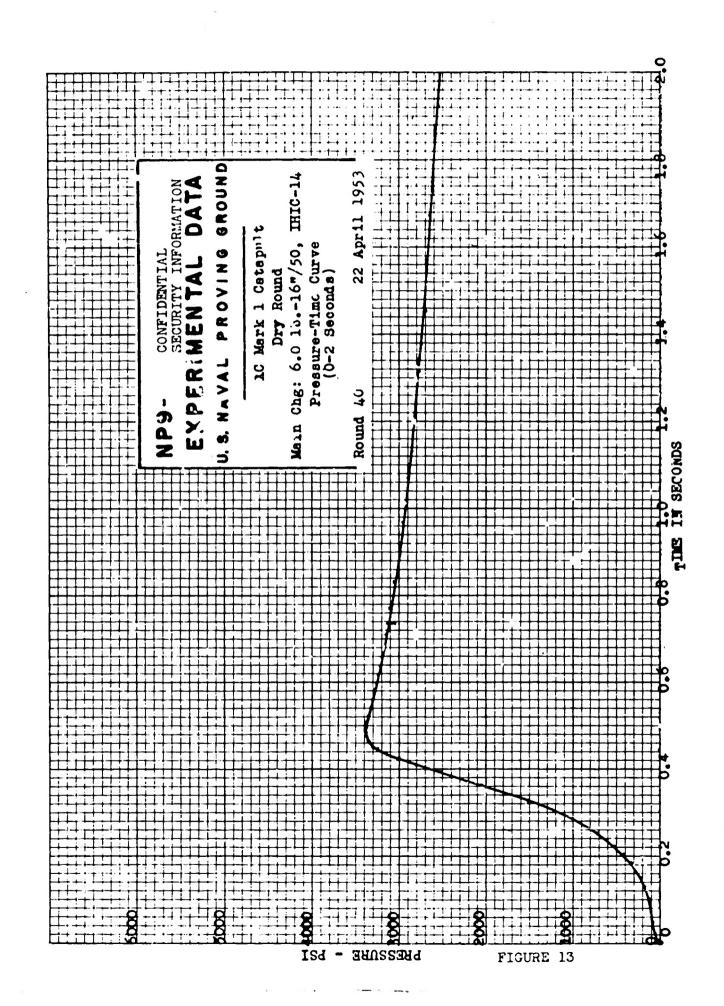


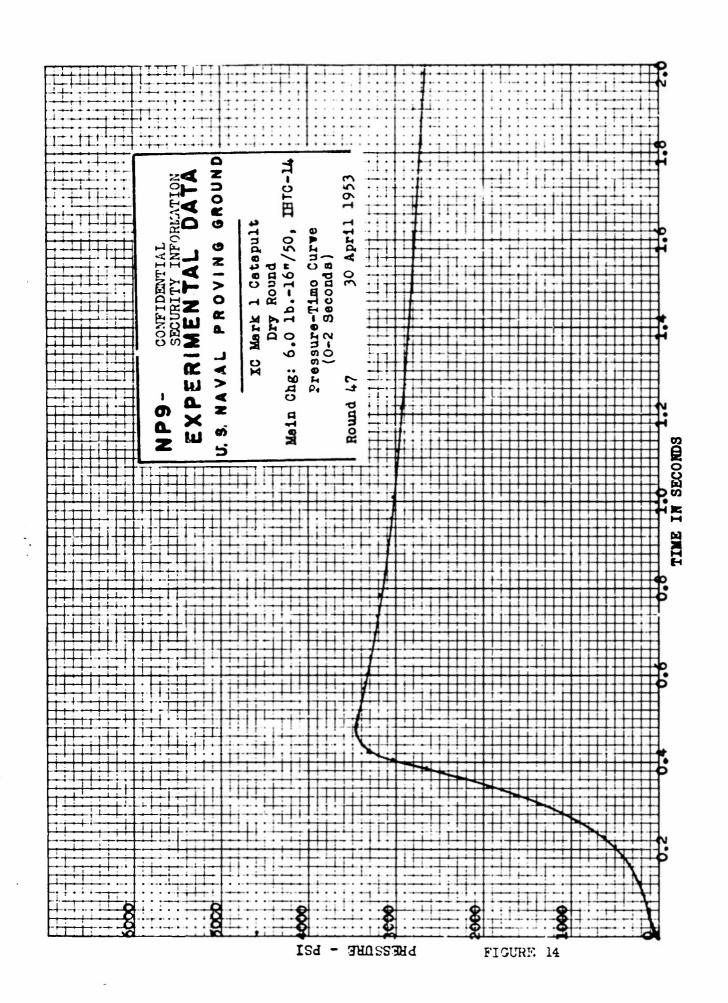
FIGURE 9

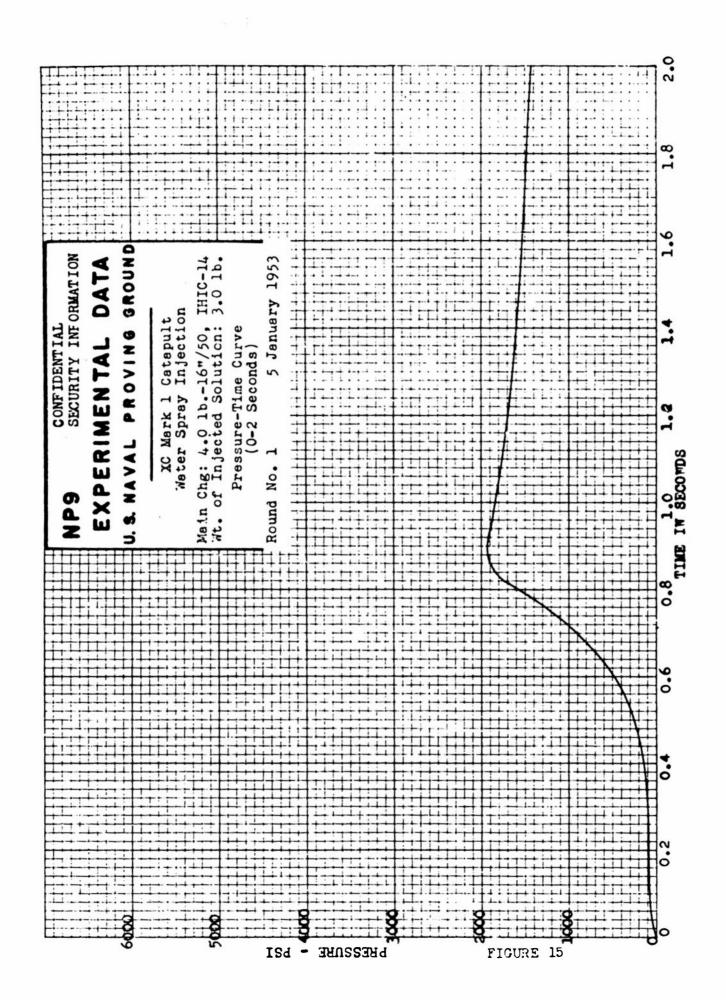


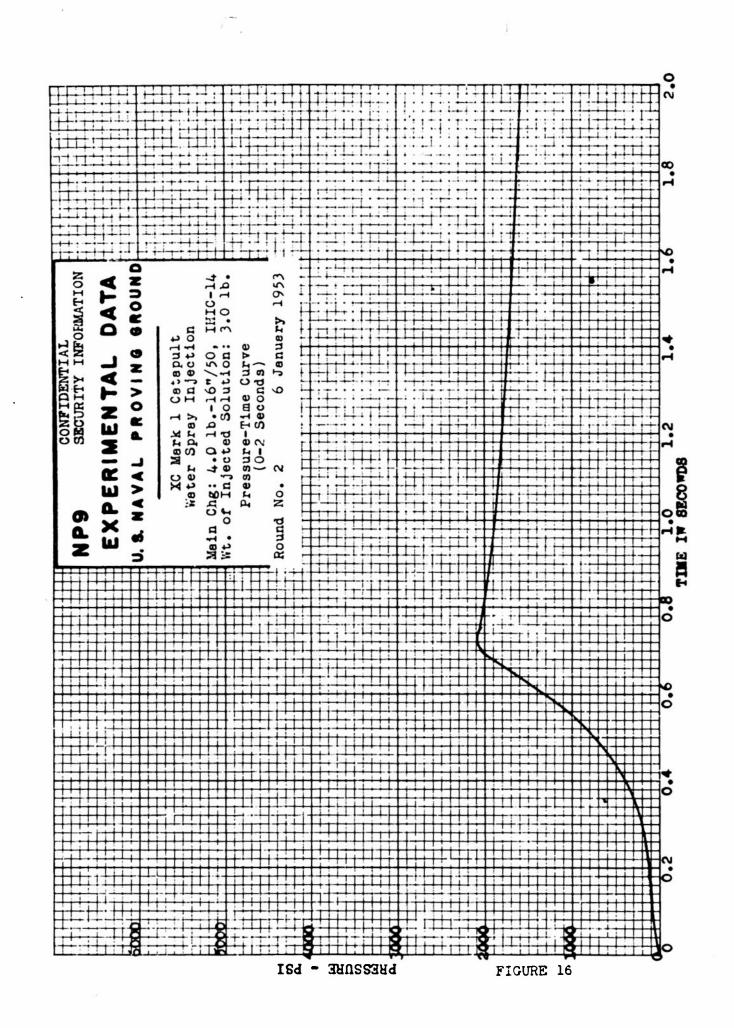


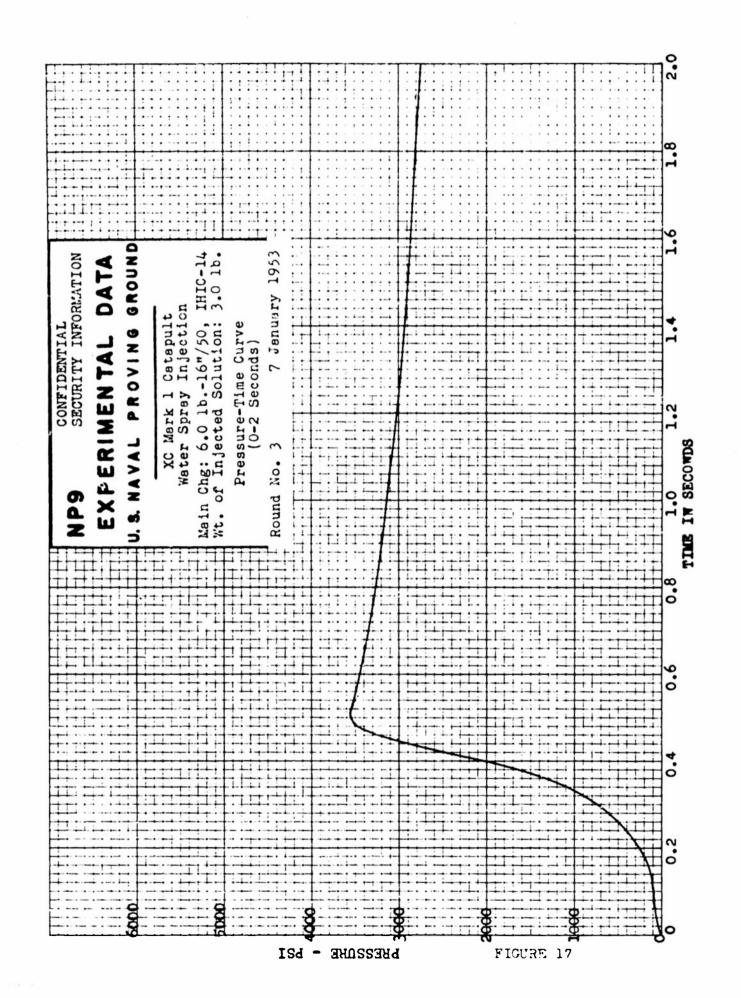


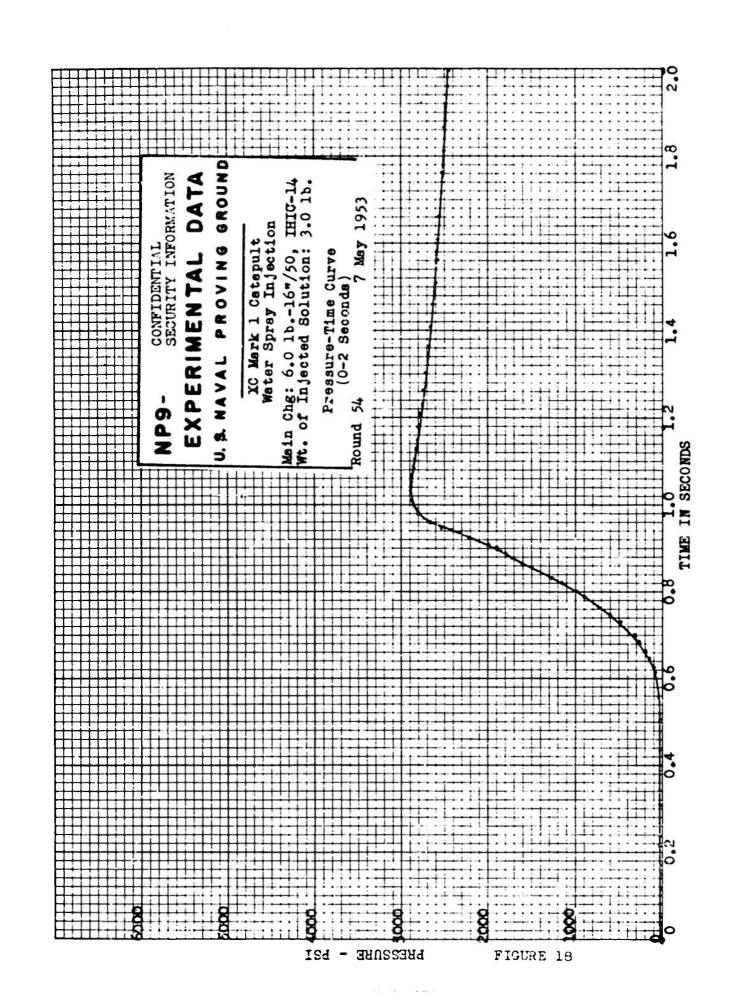


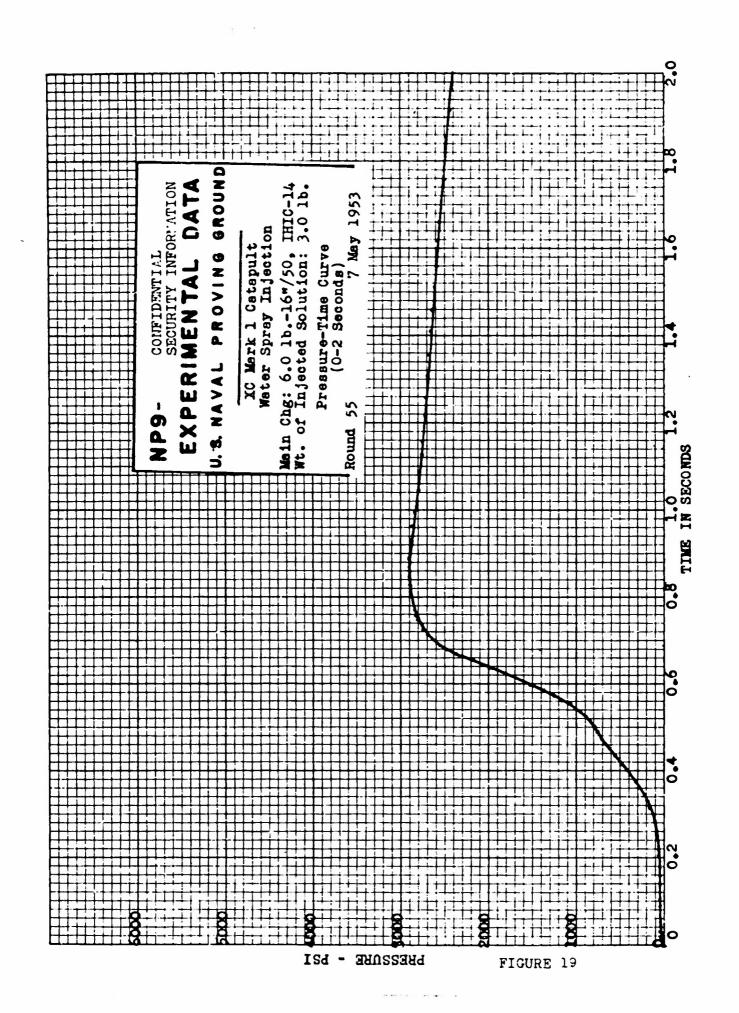


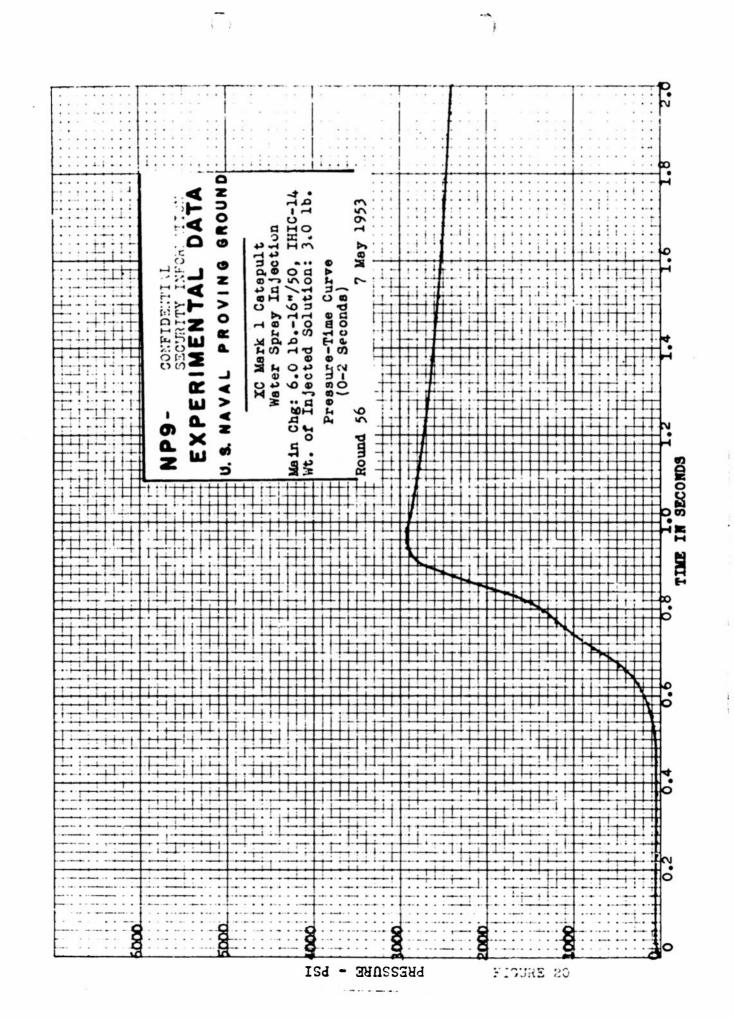


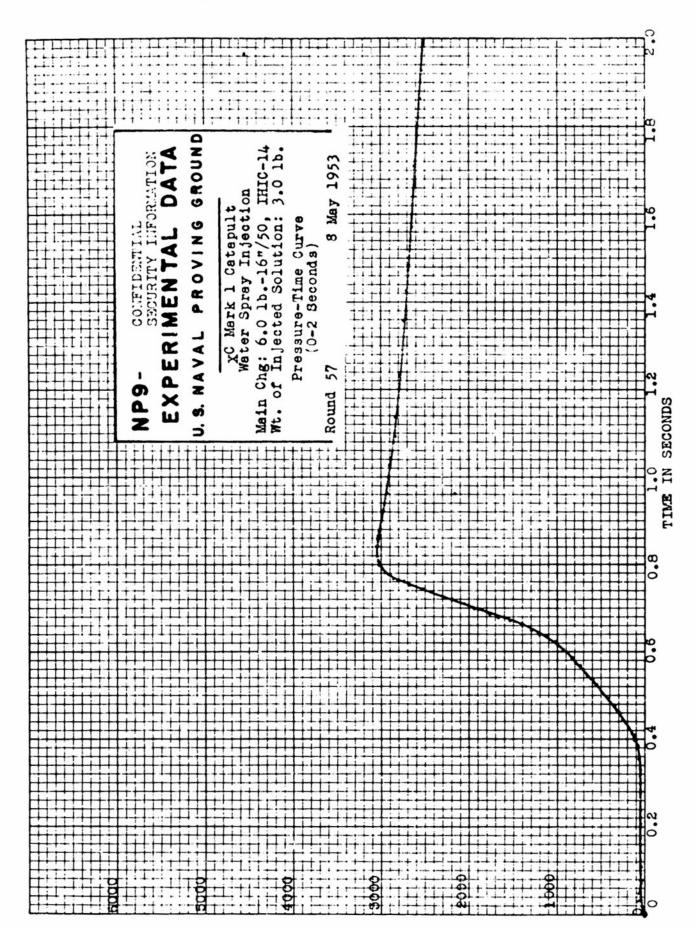


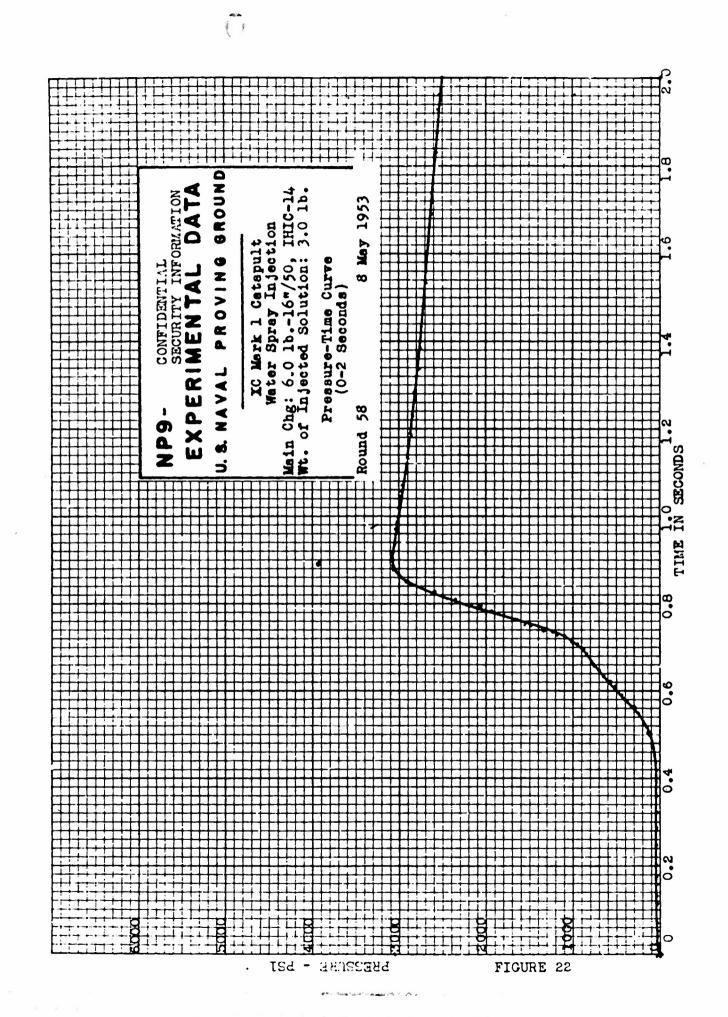


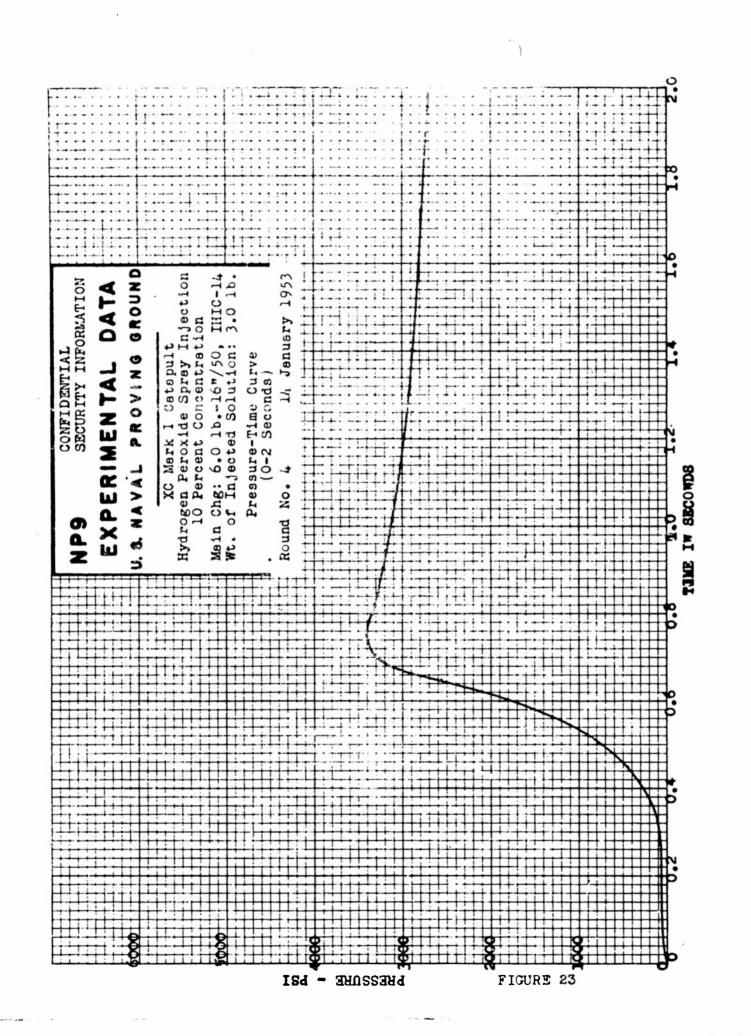


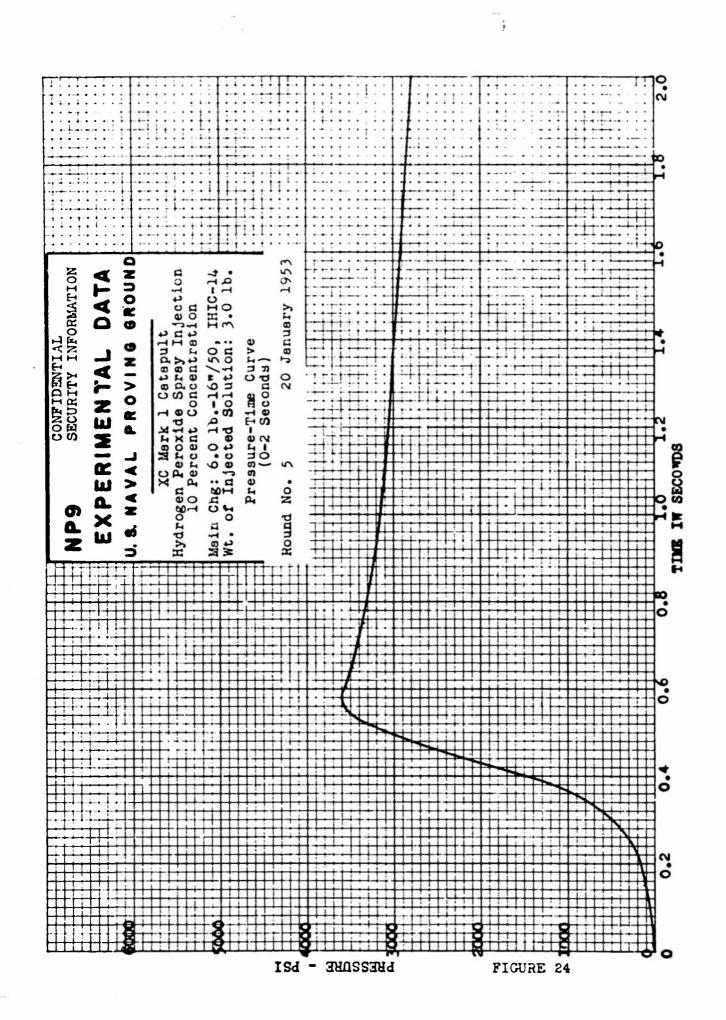


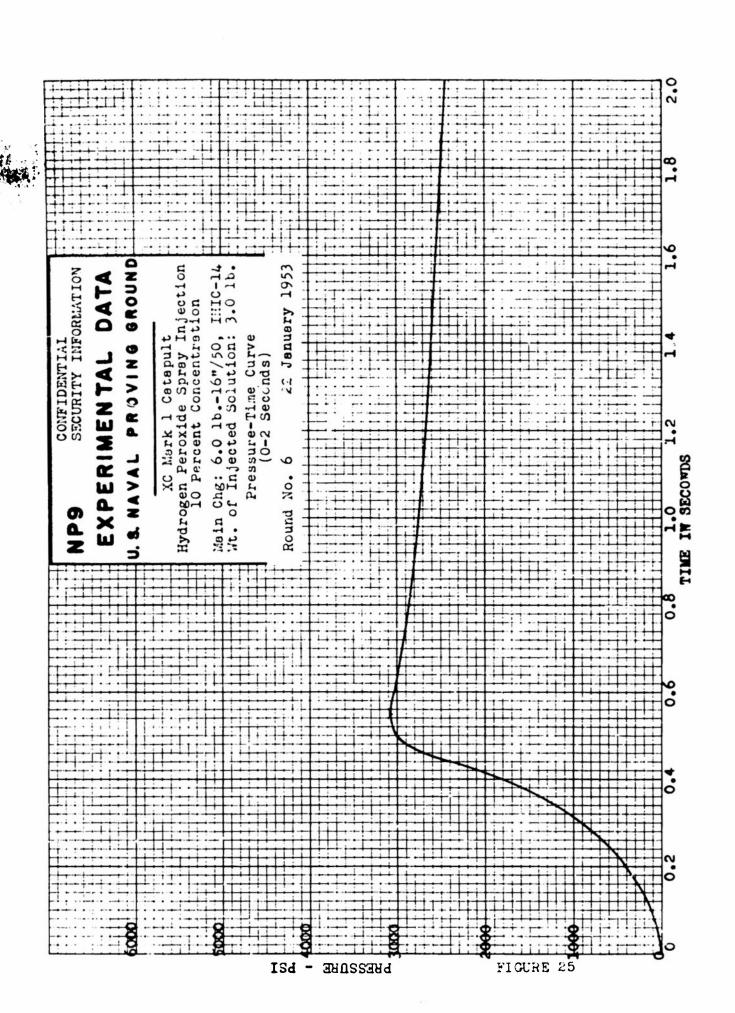


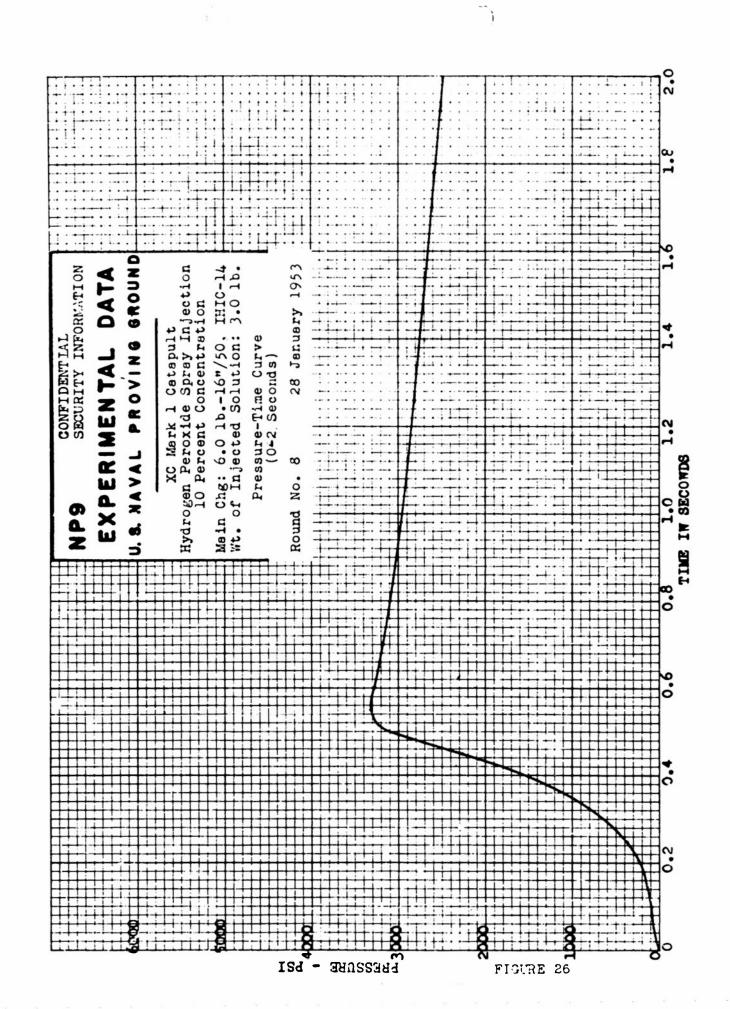


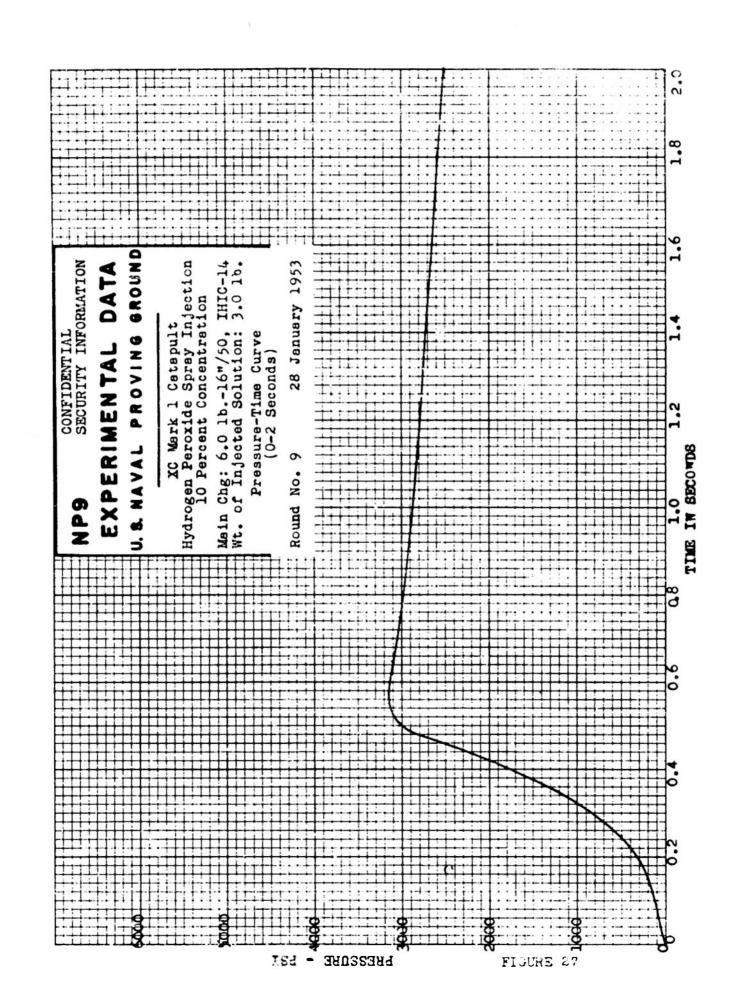


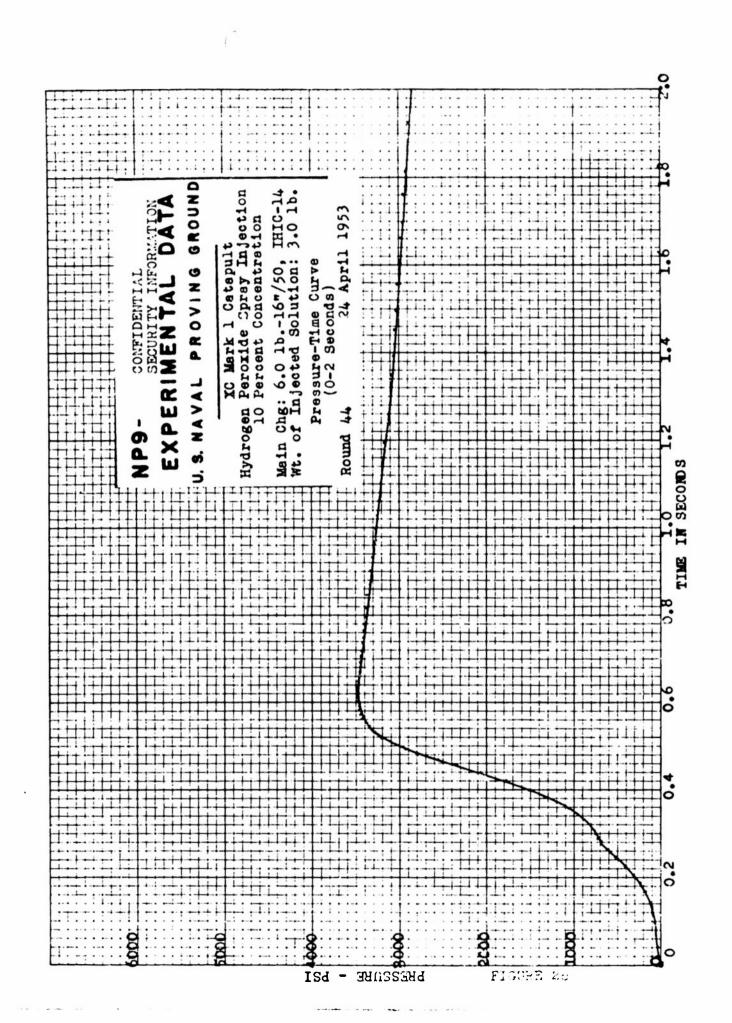


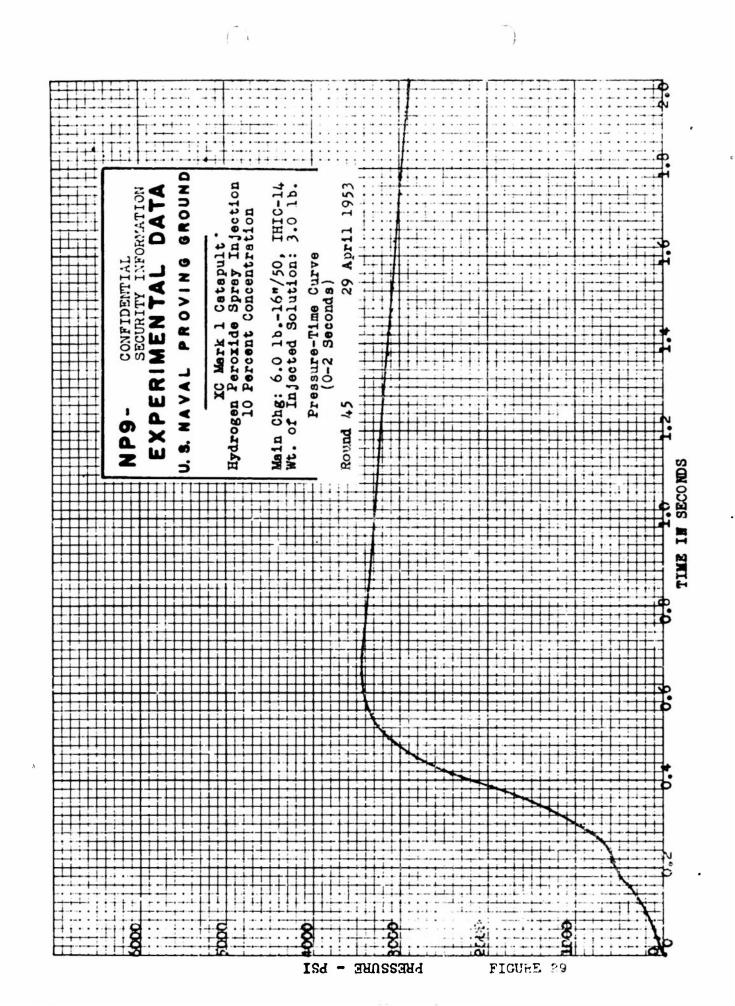


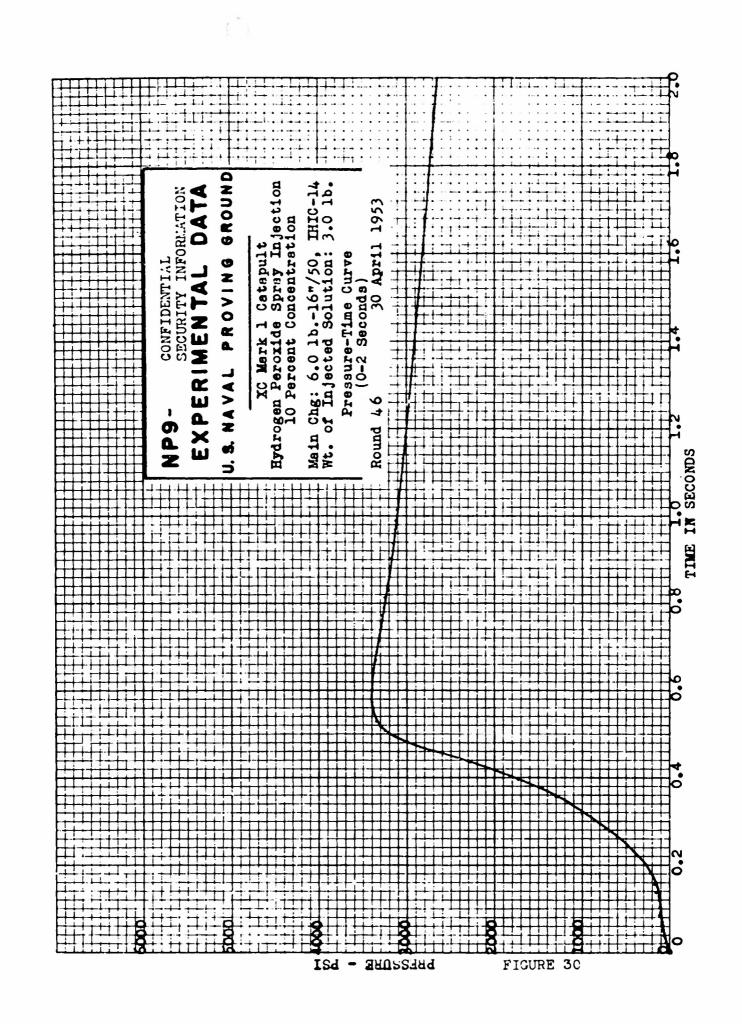


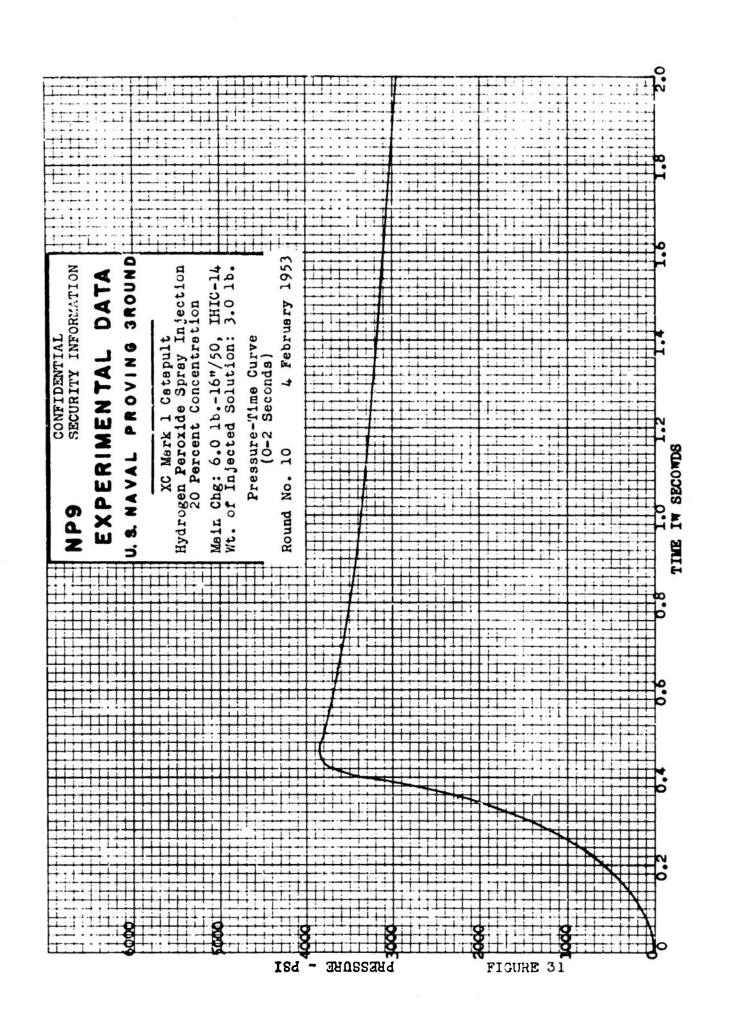


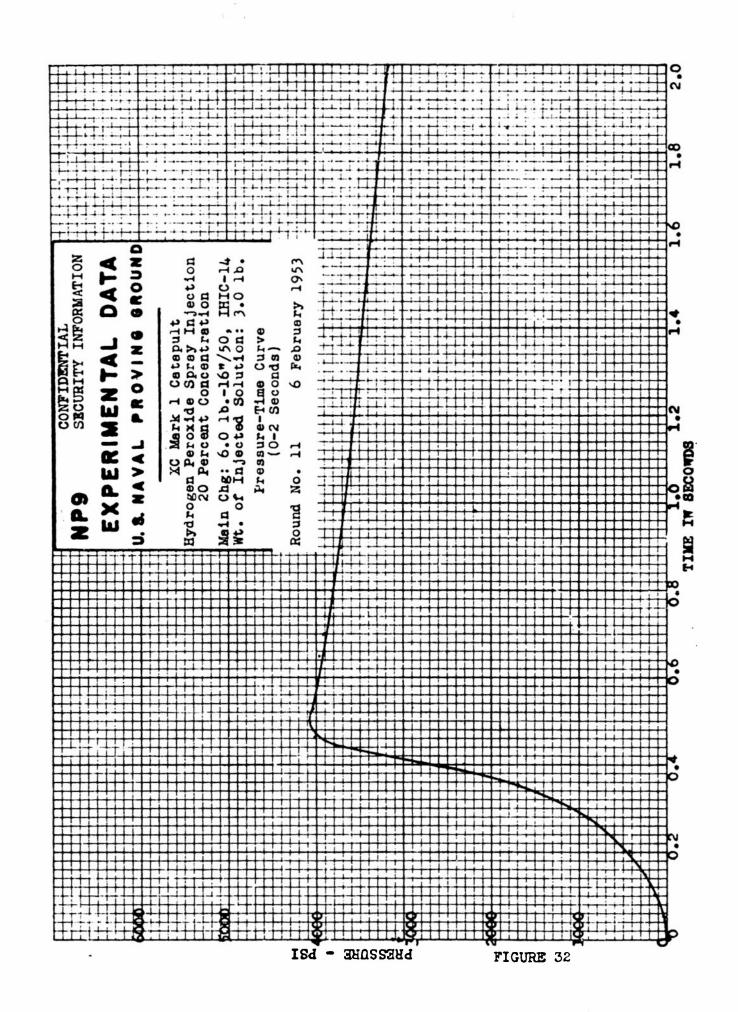


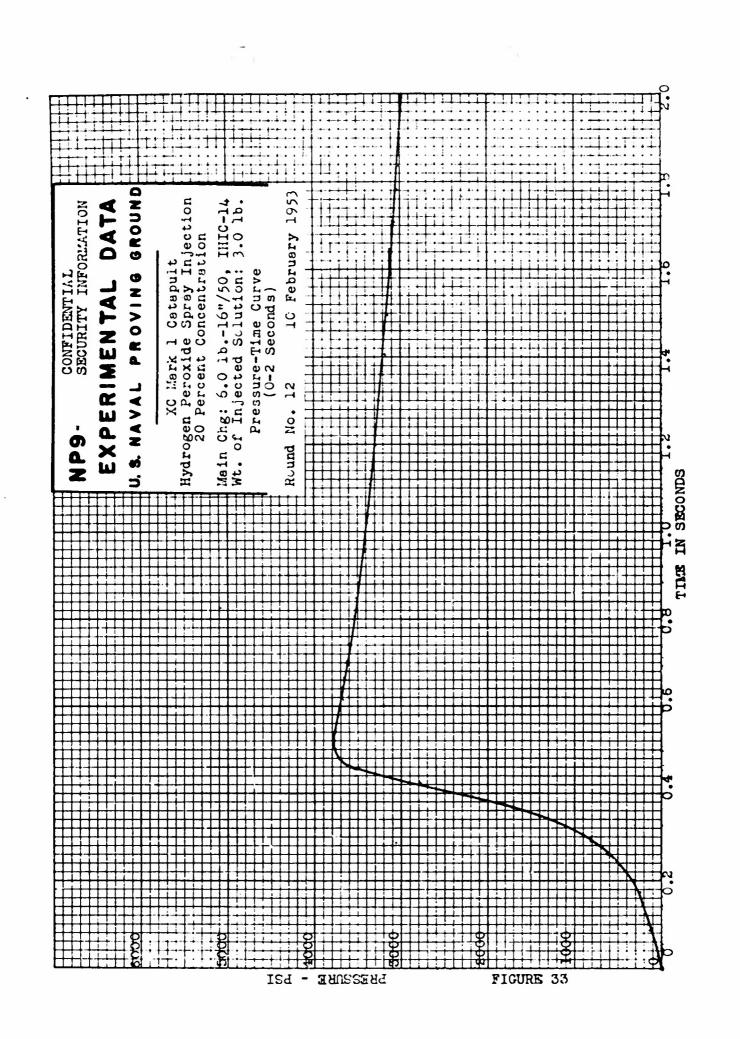


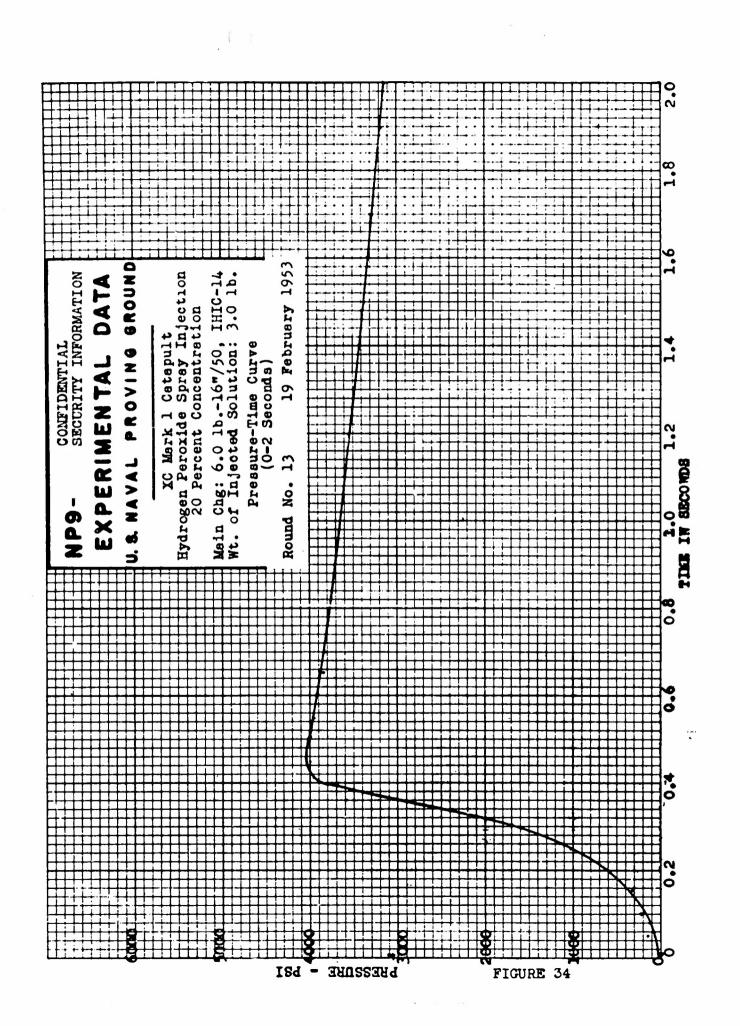


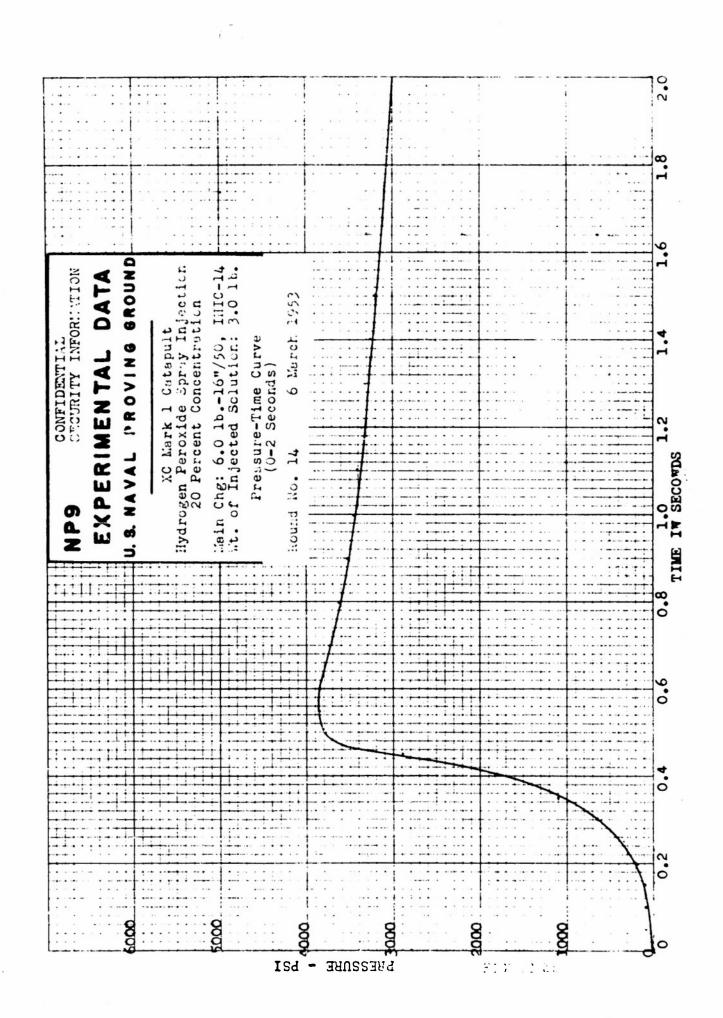


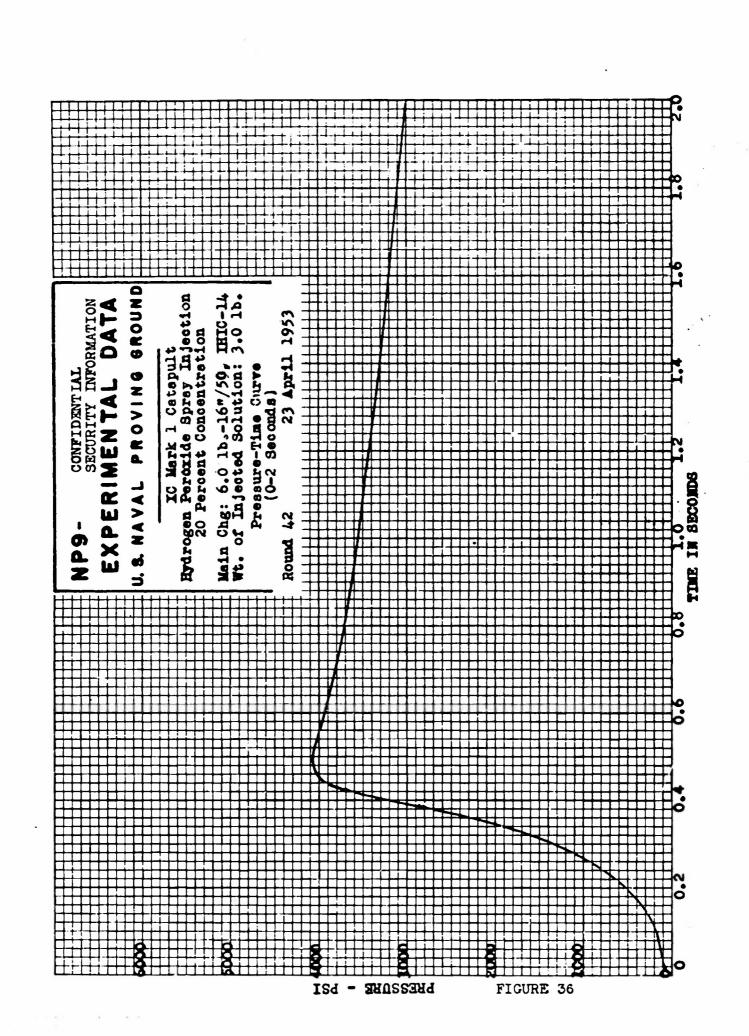


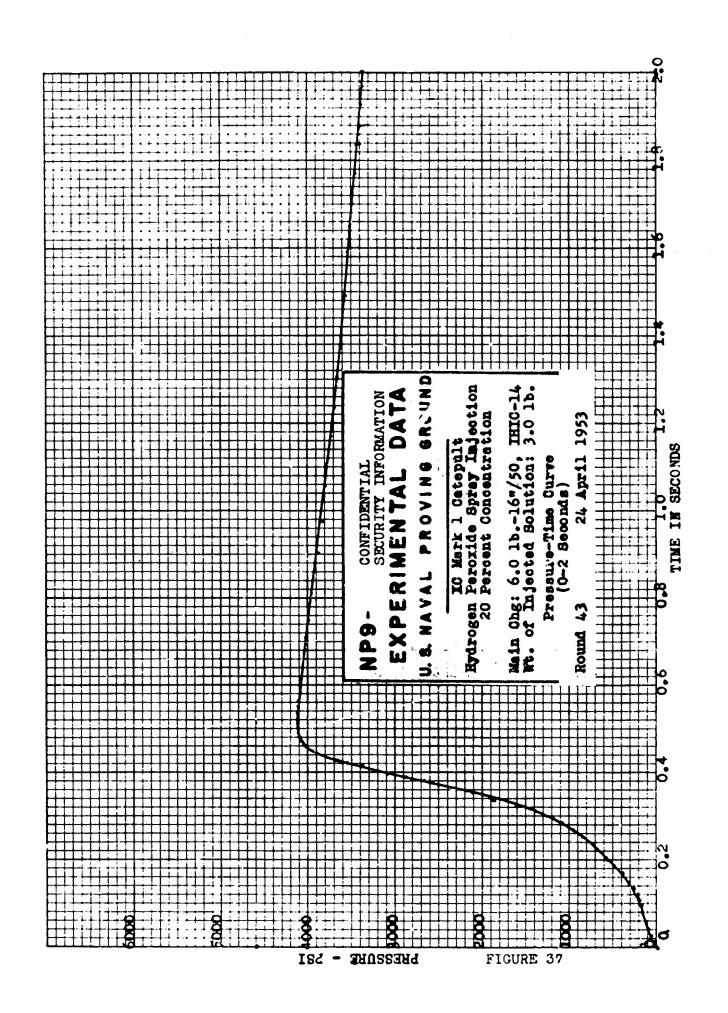


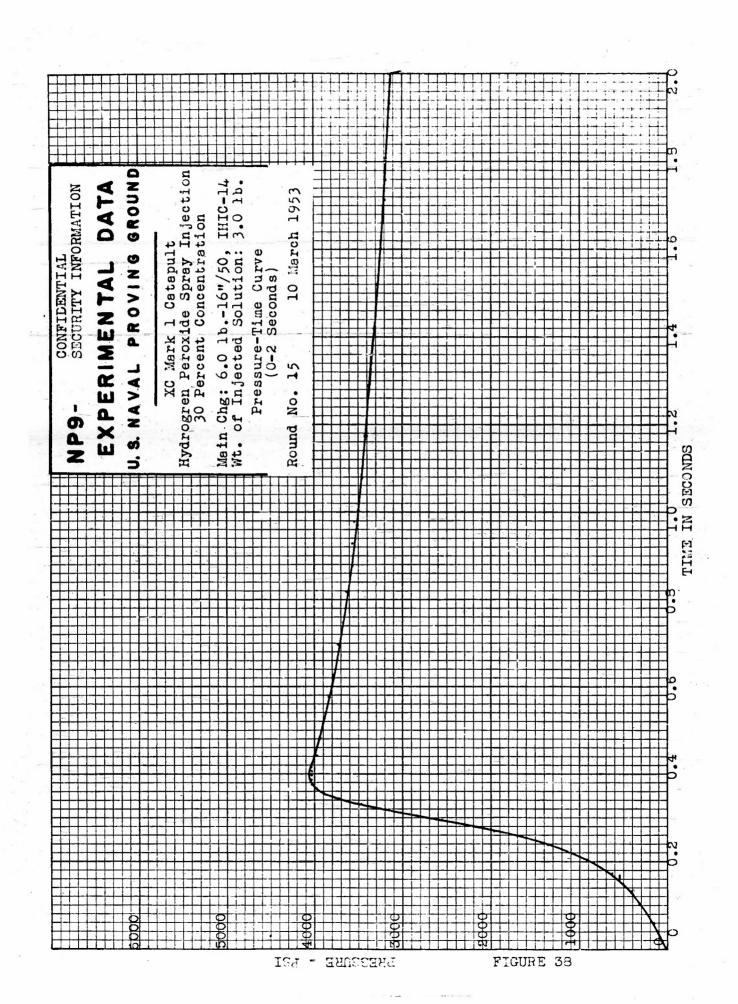


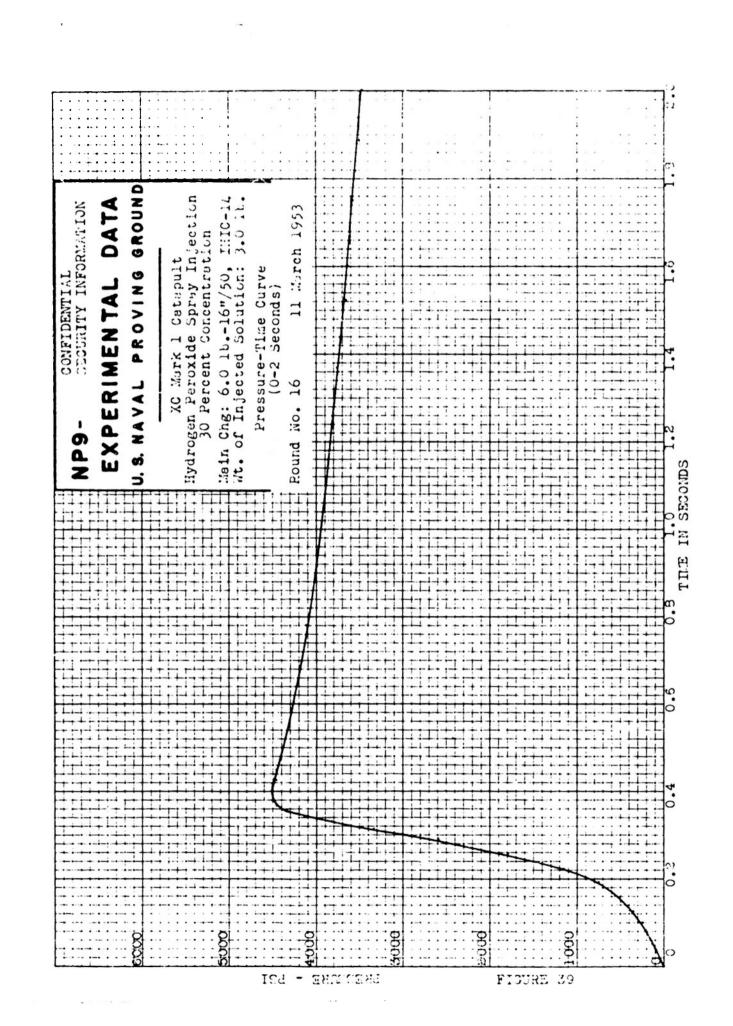


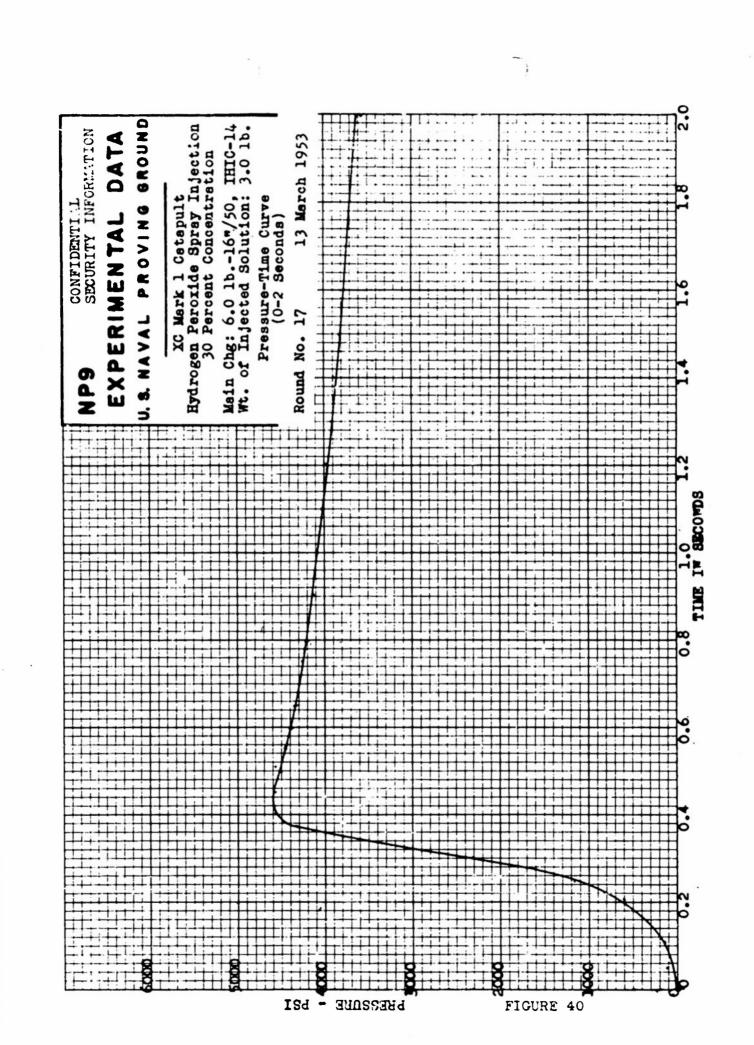


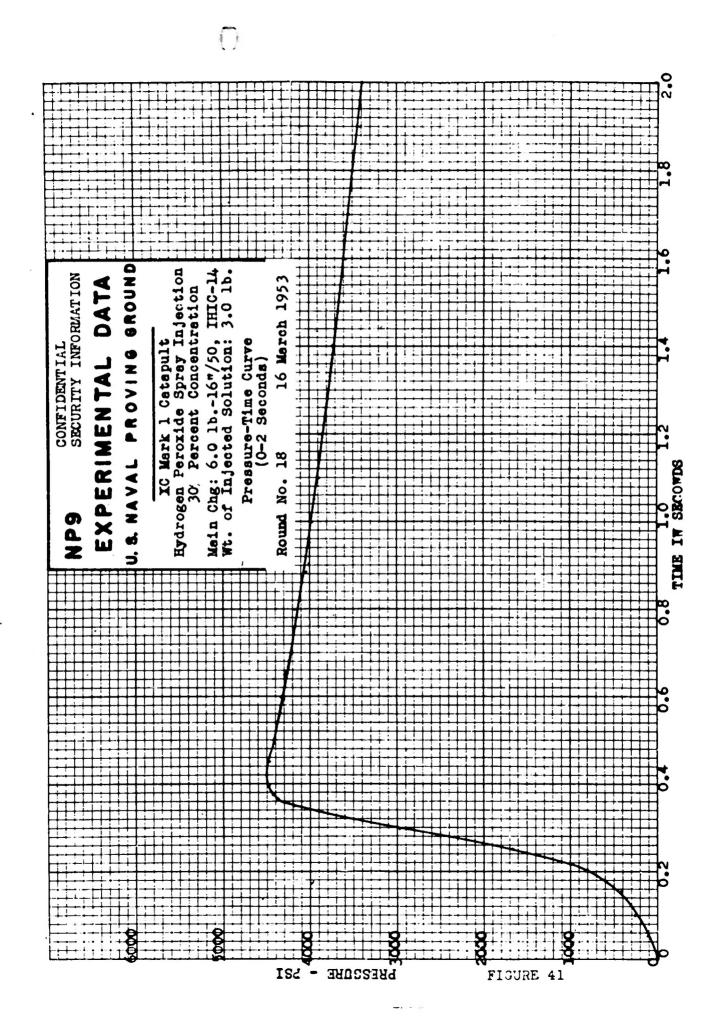


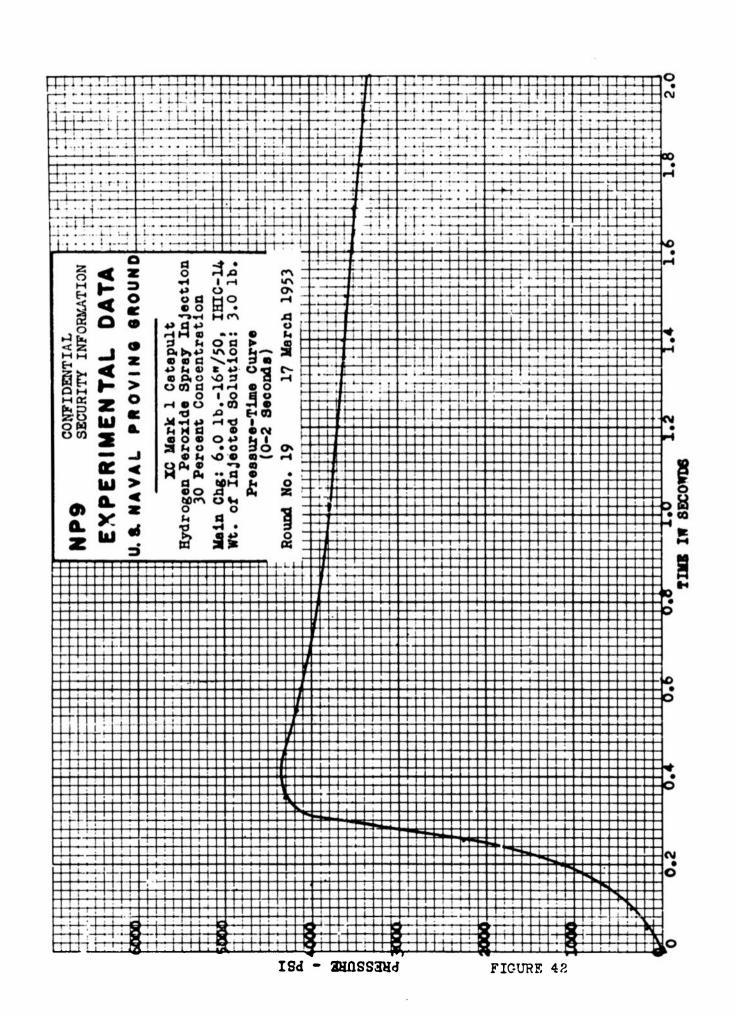


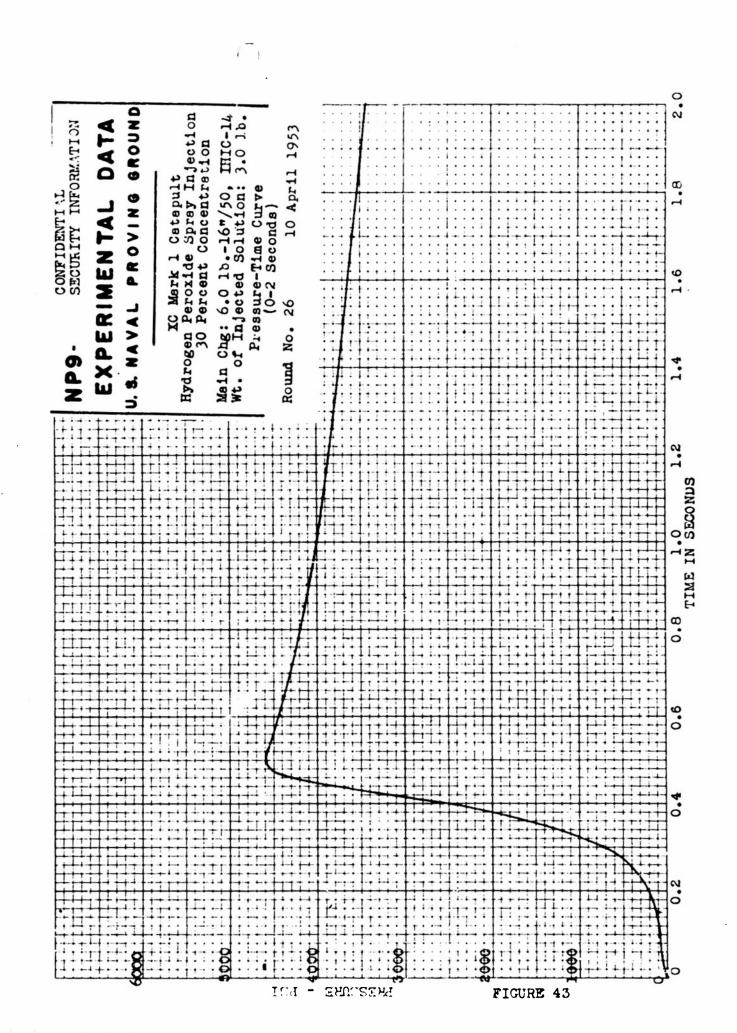


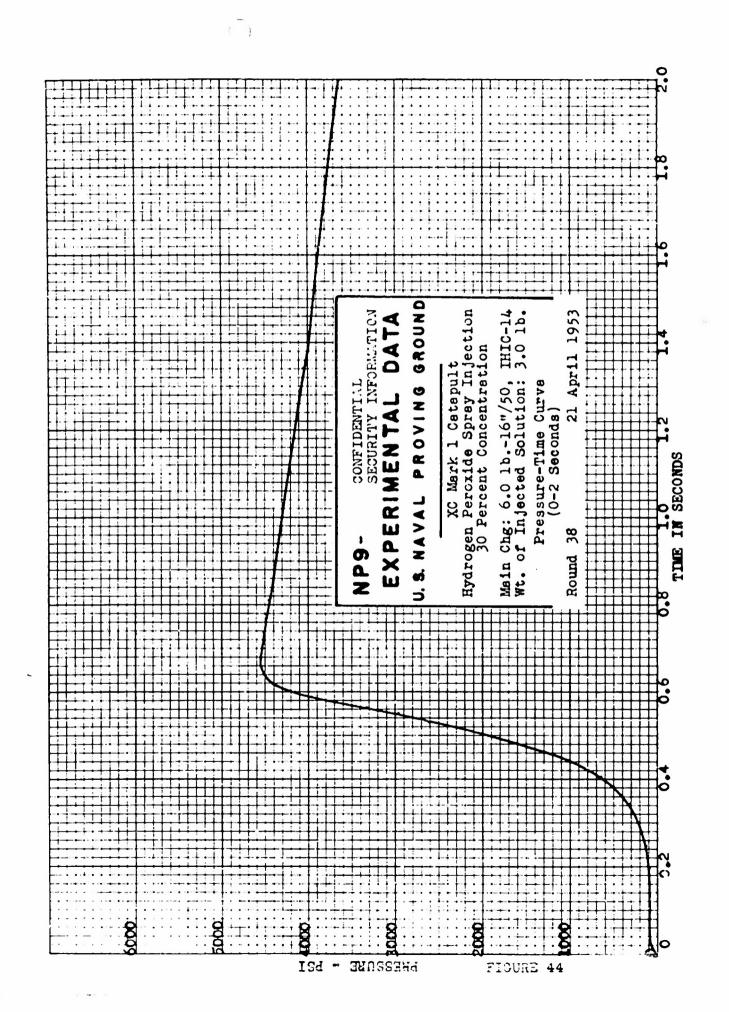


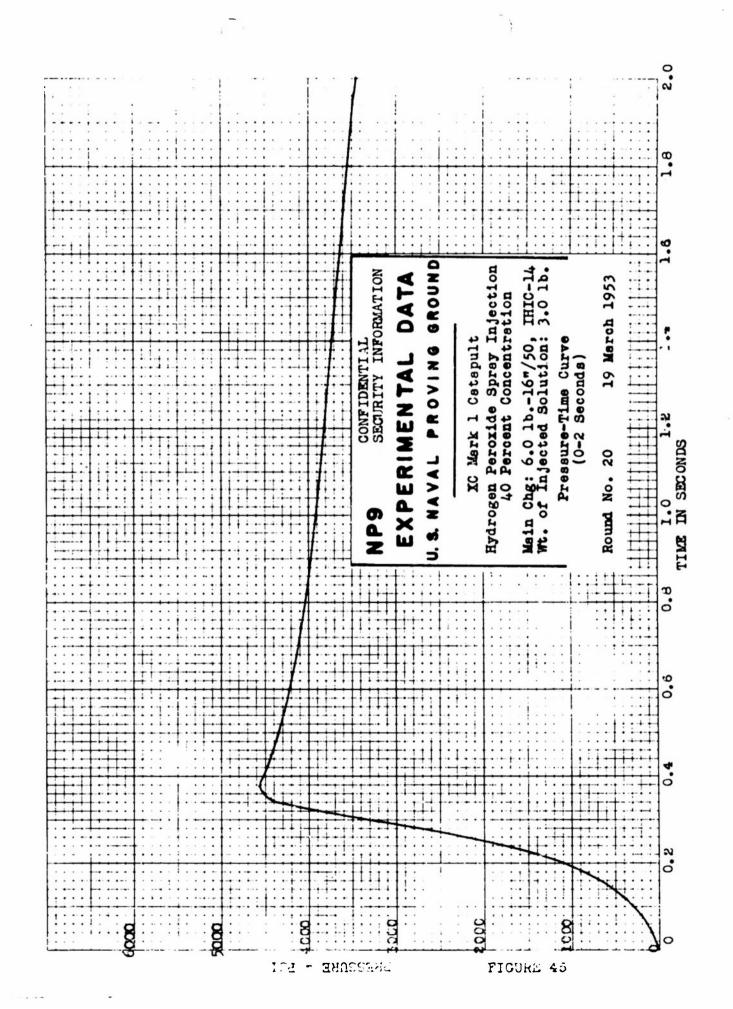


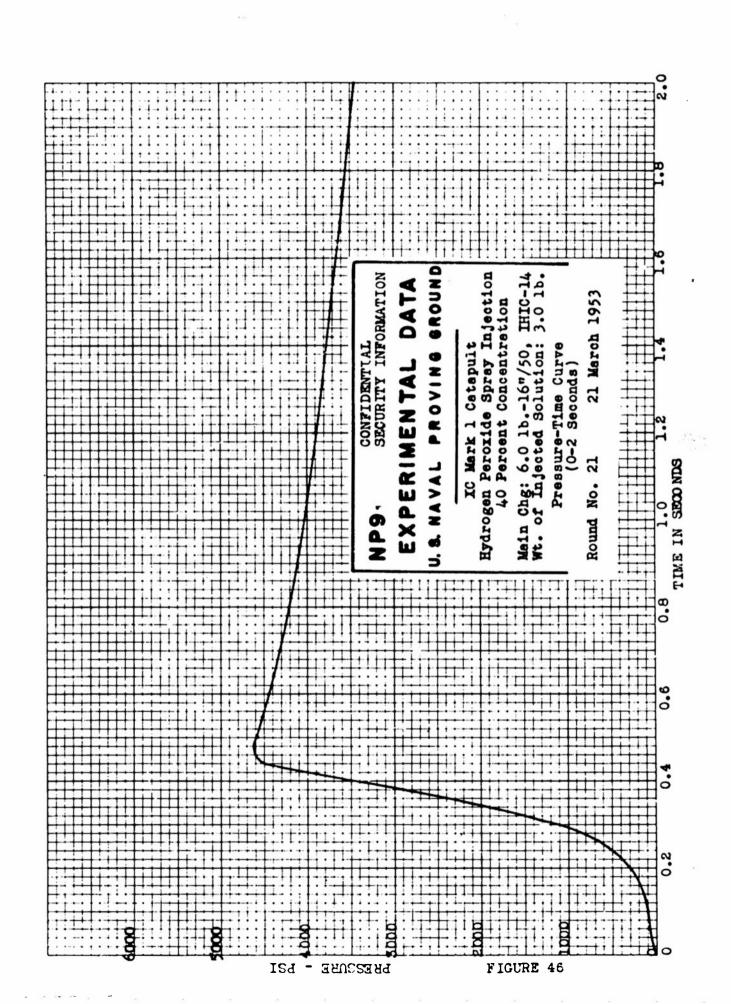


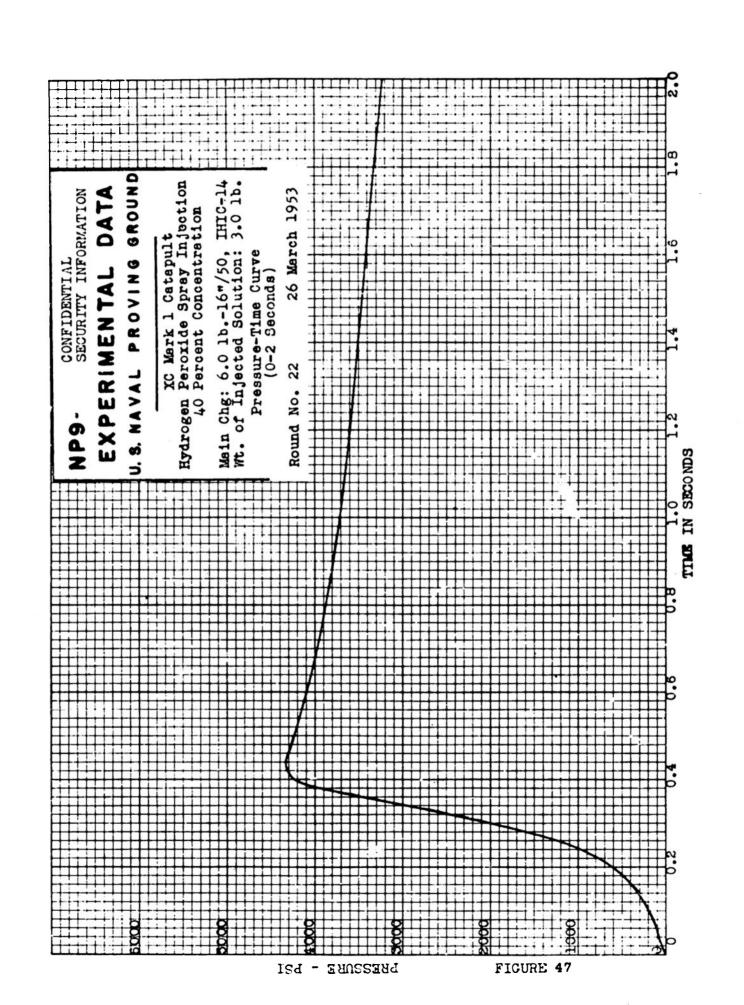


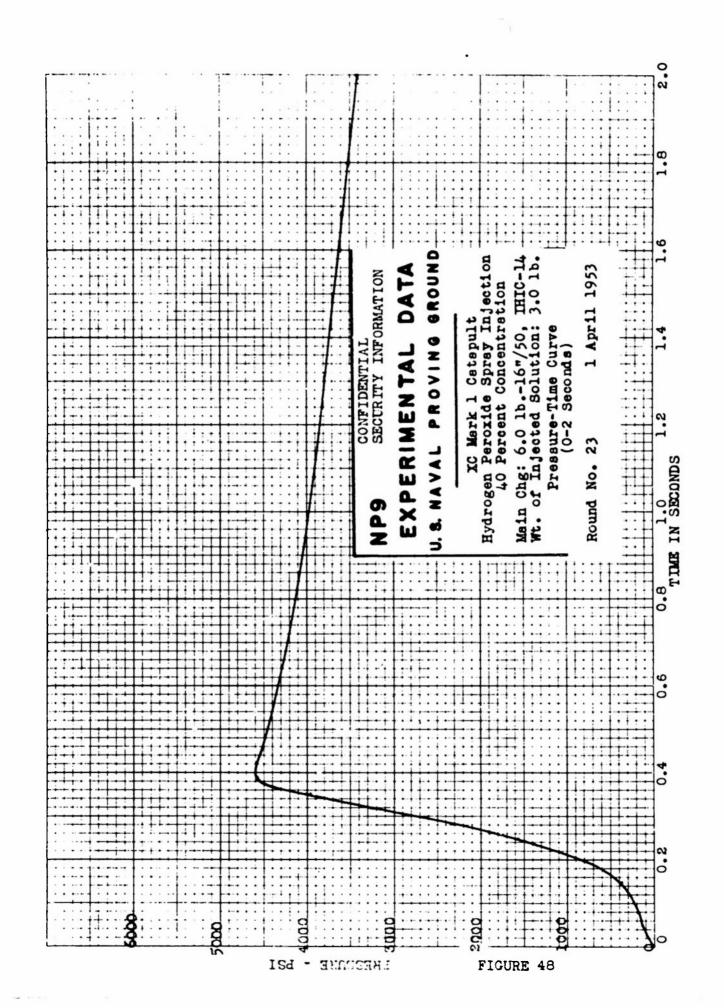


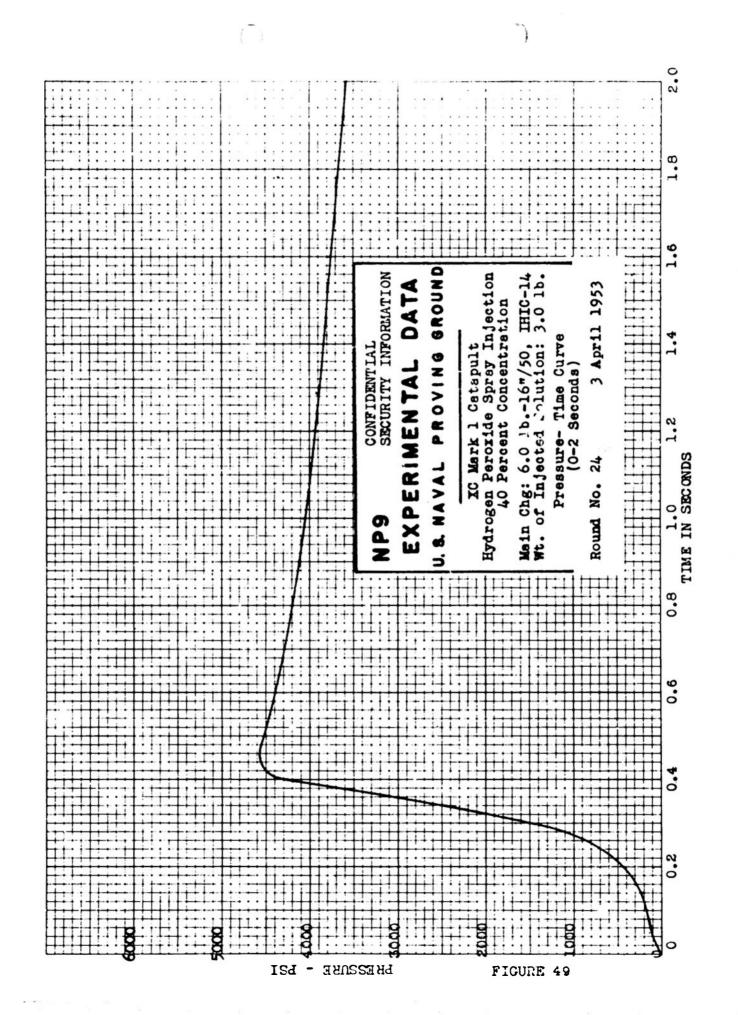


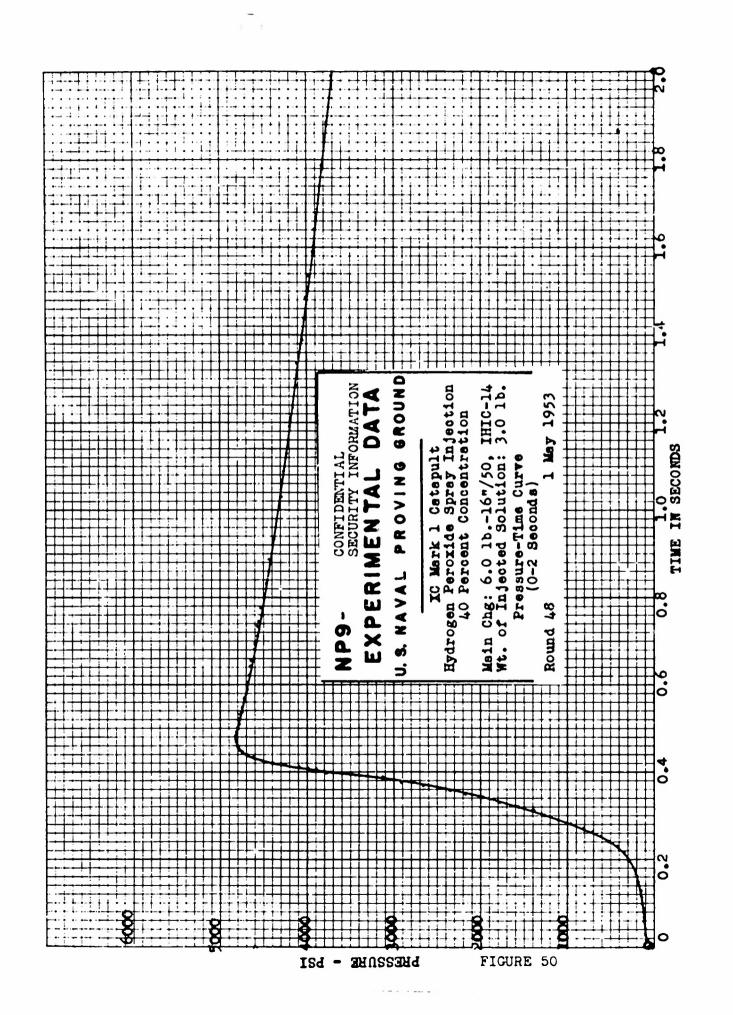


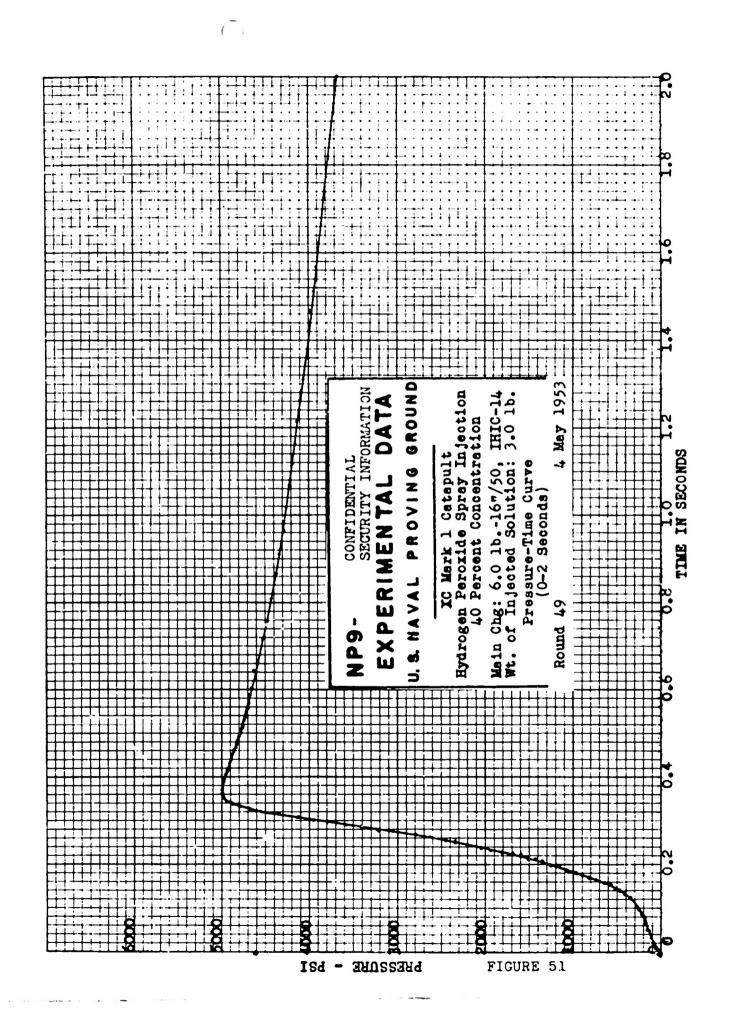


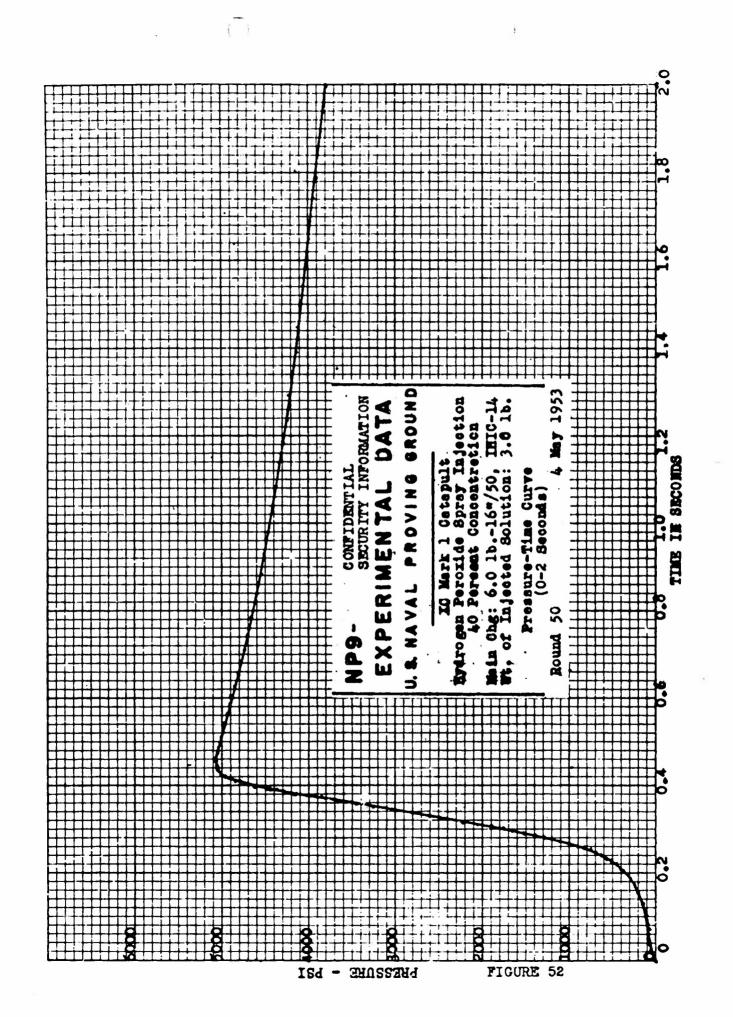


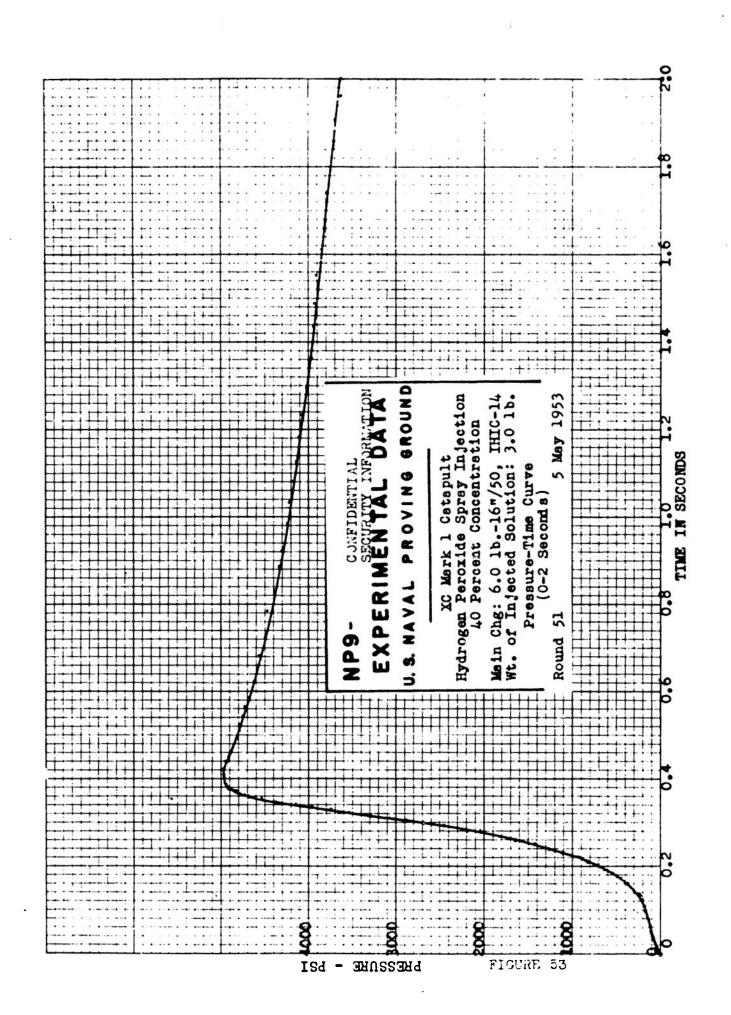


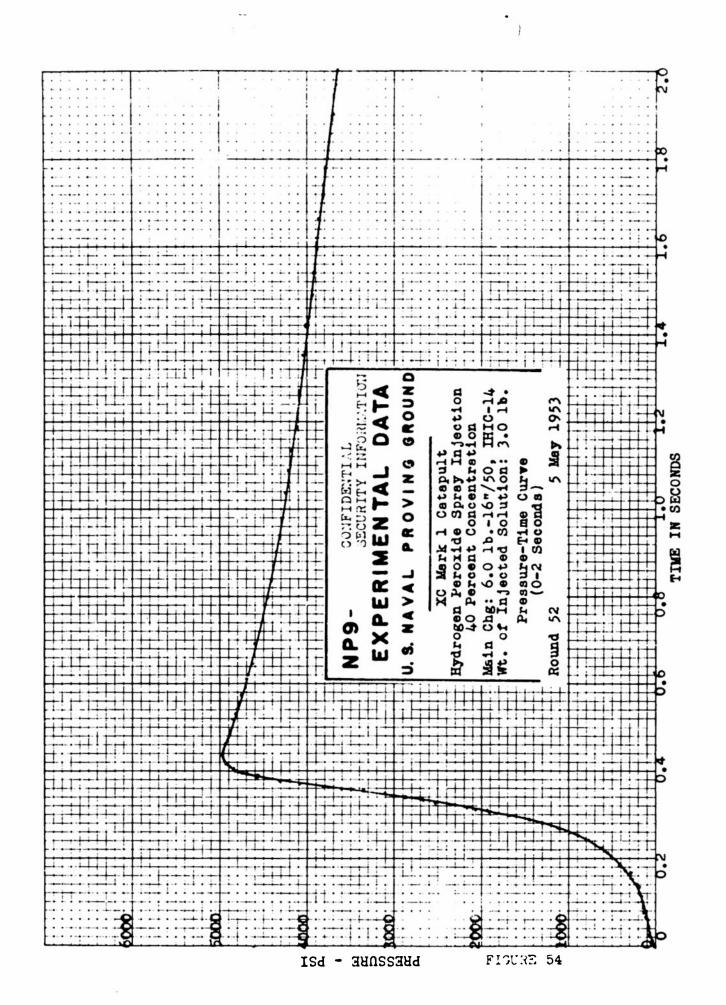


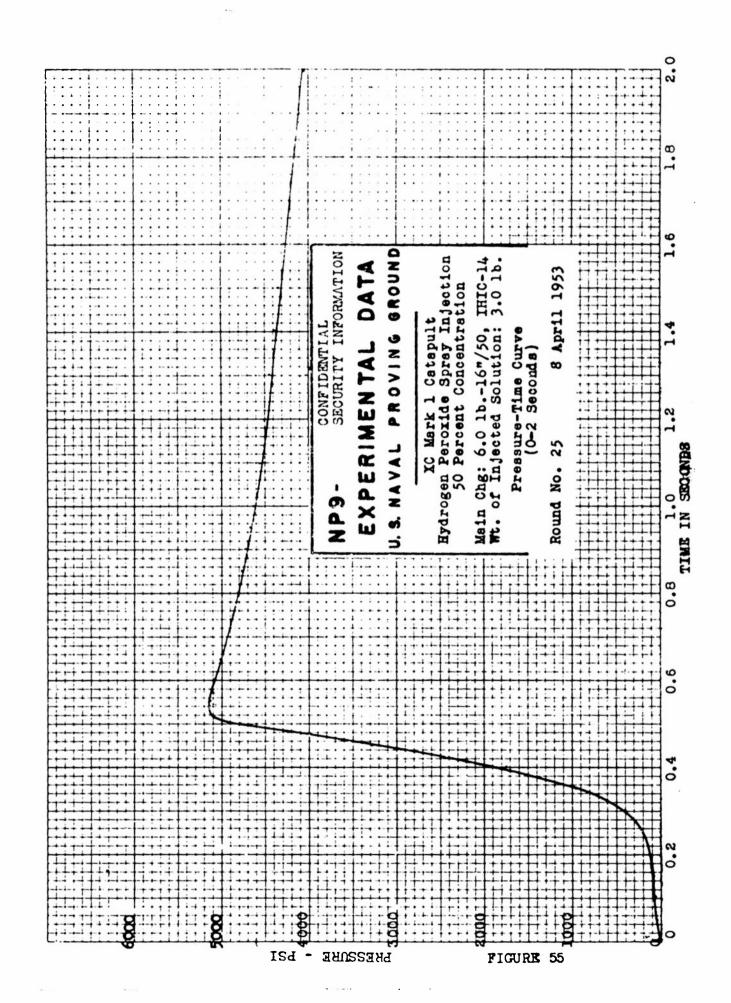


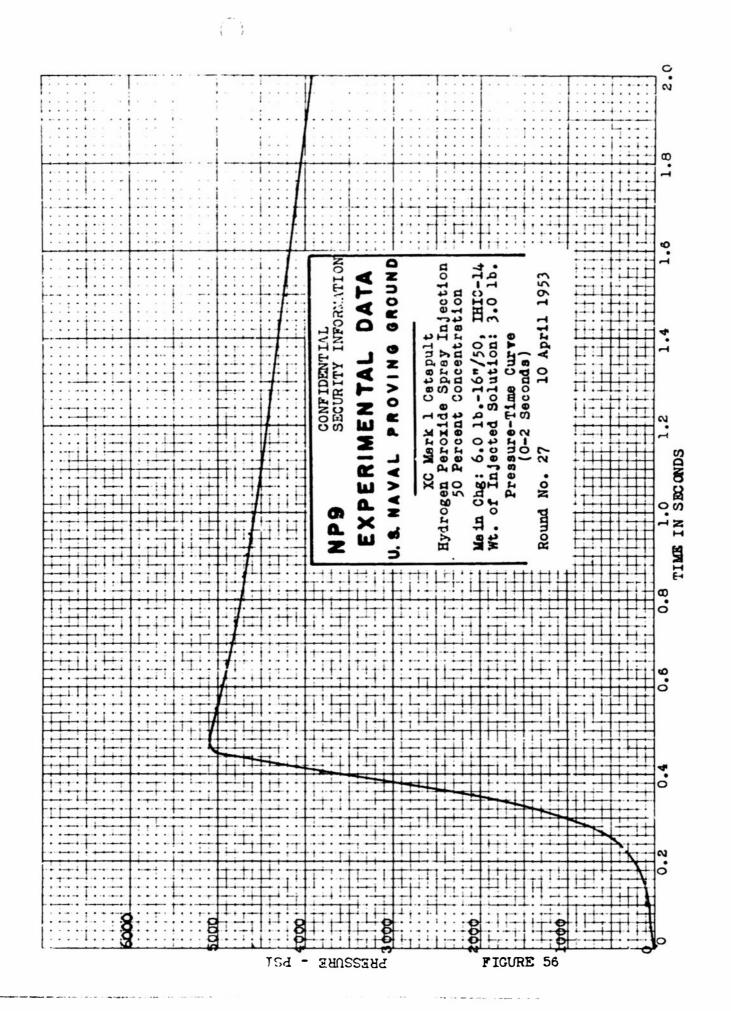


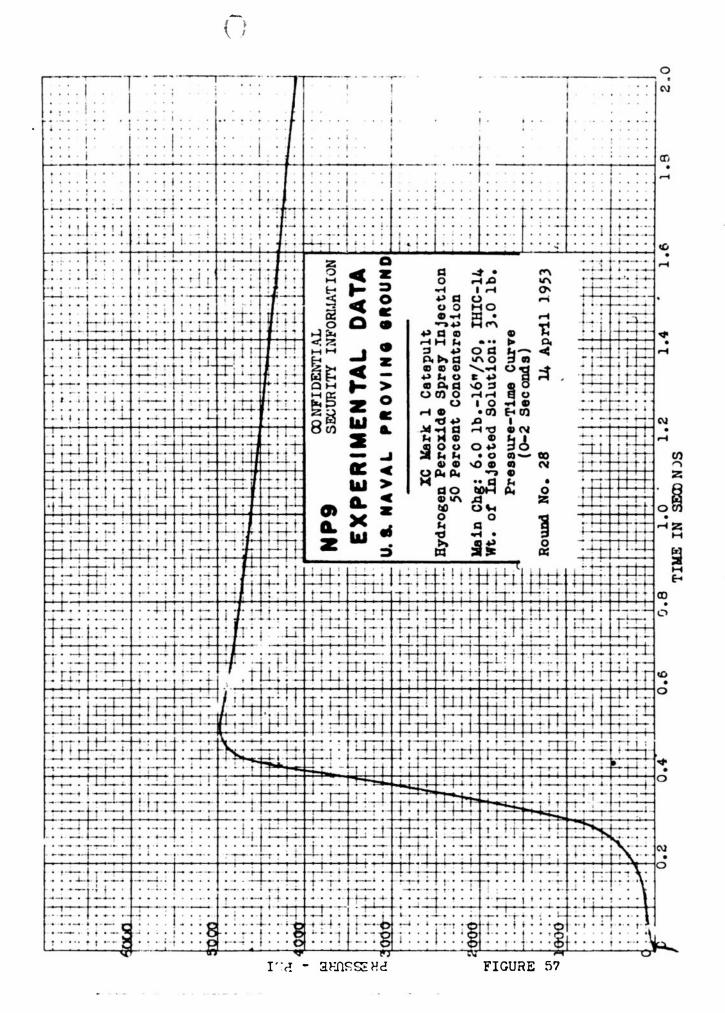


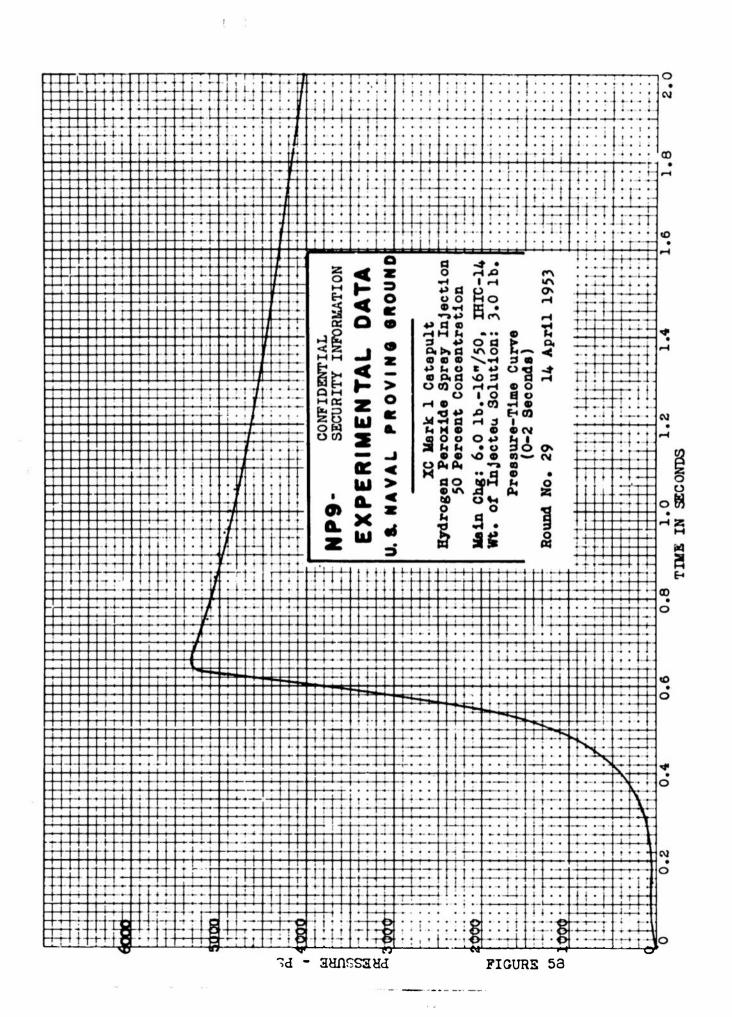


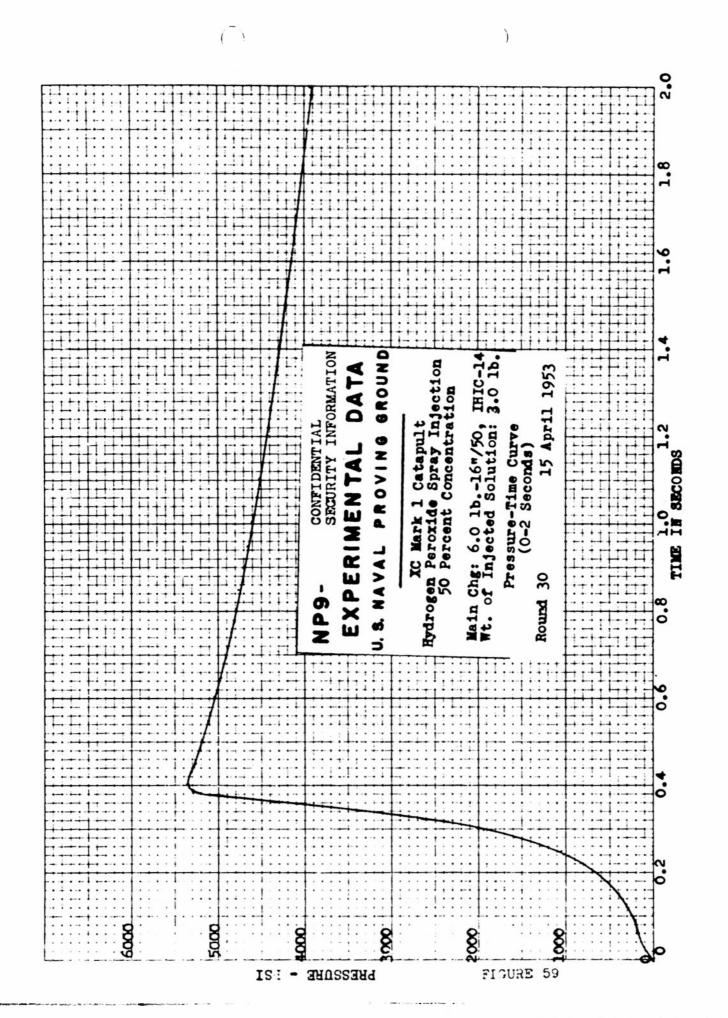


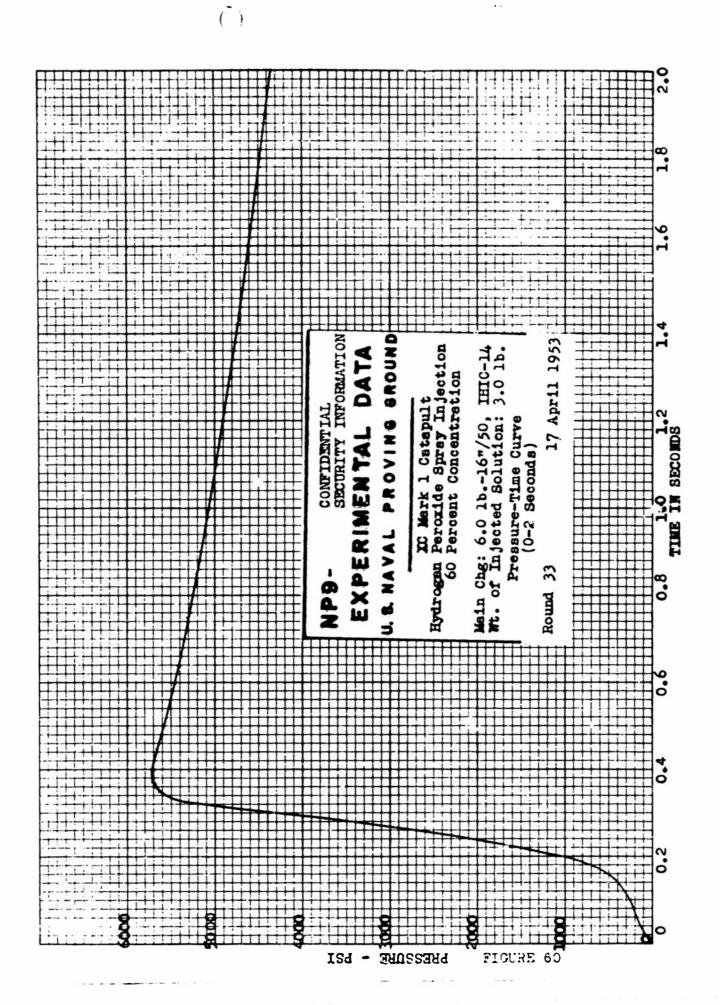


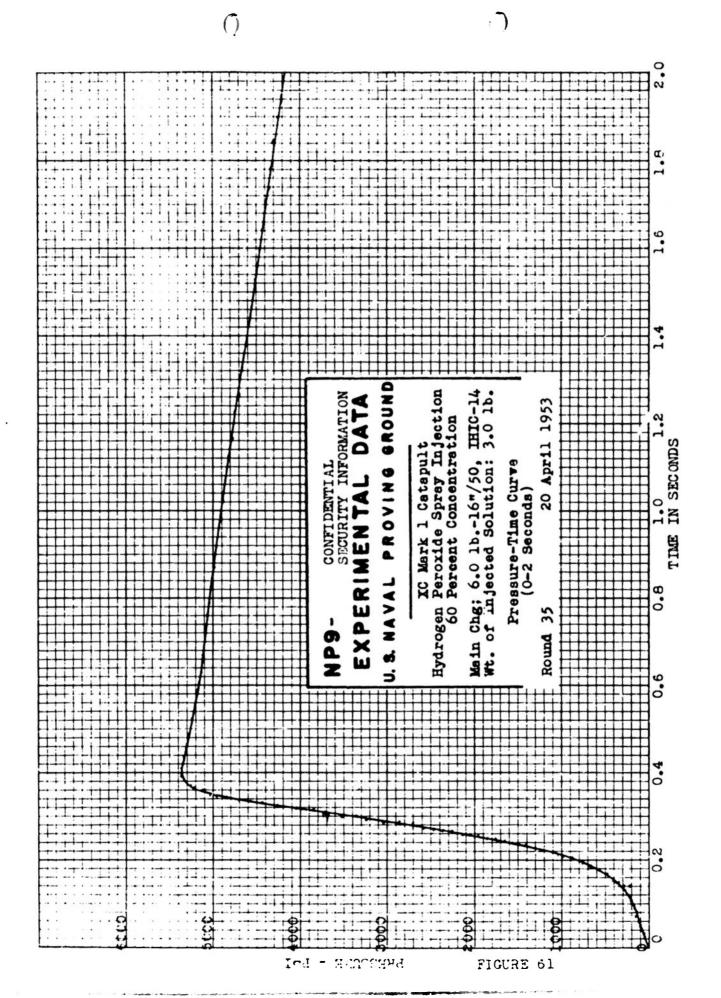


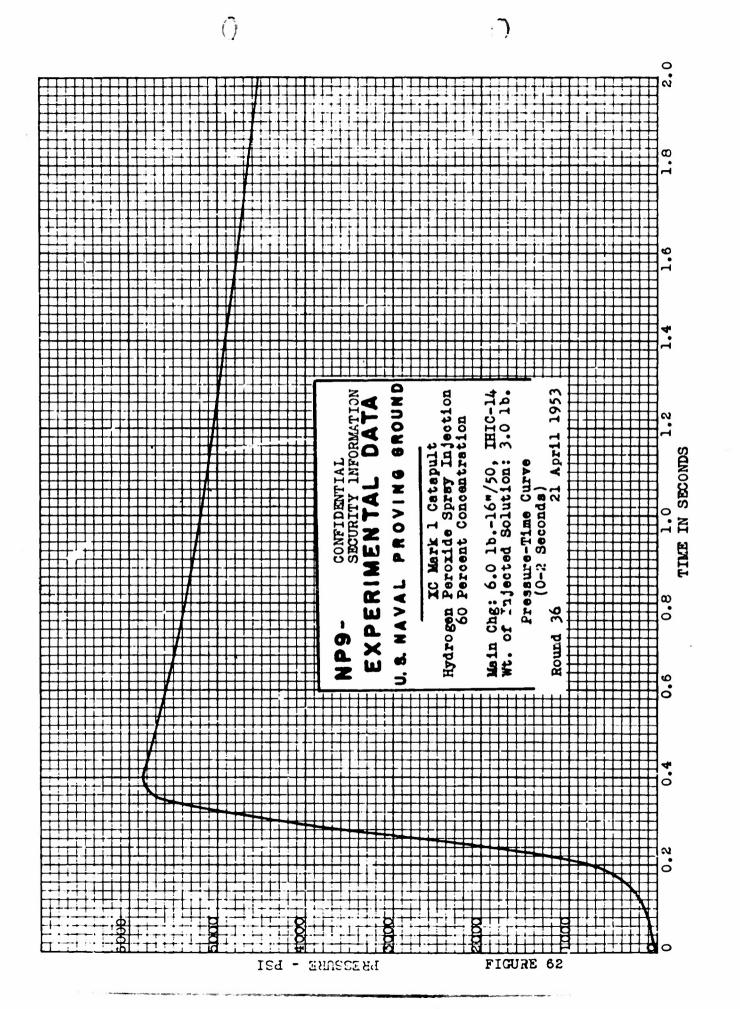


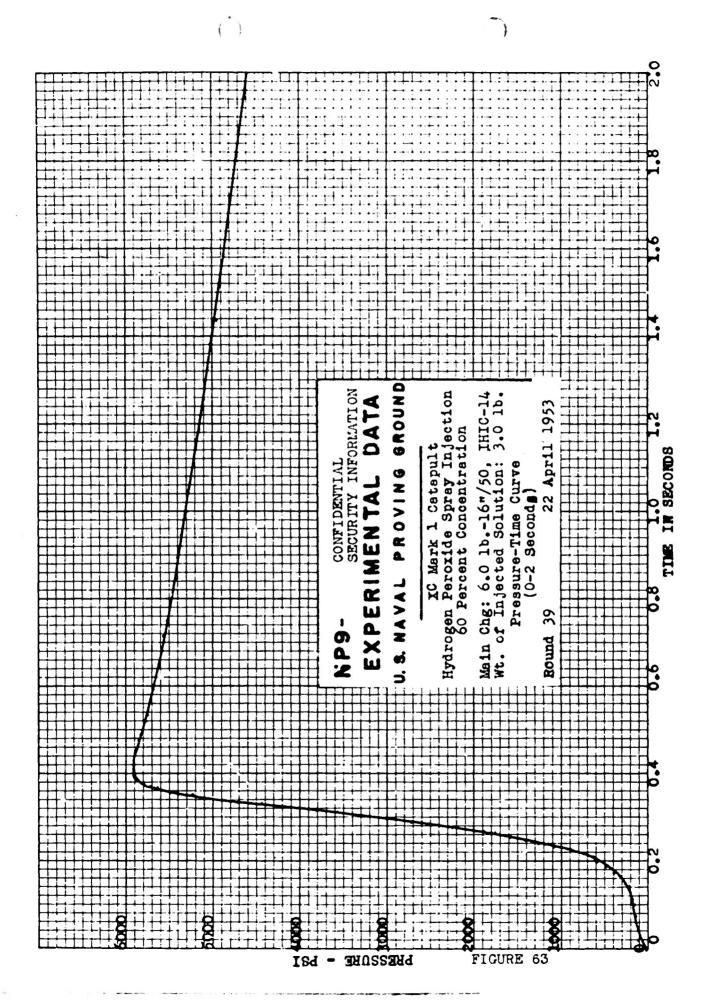


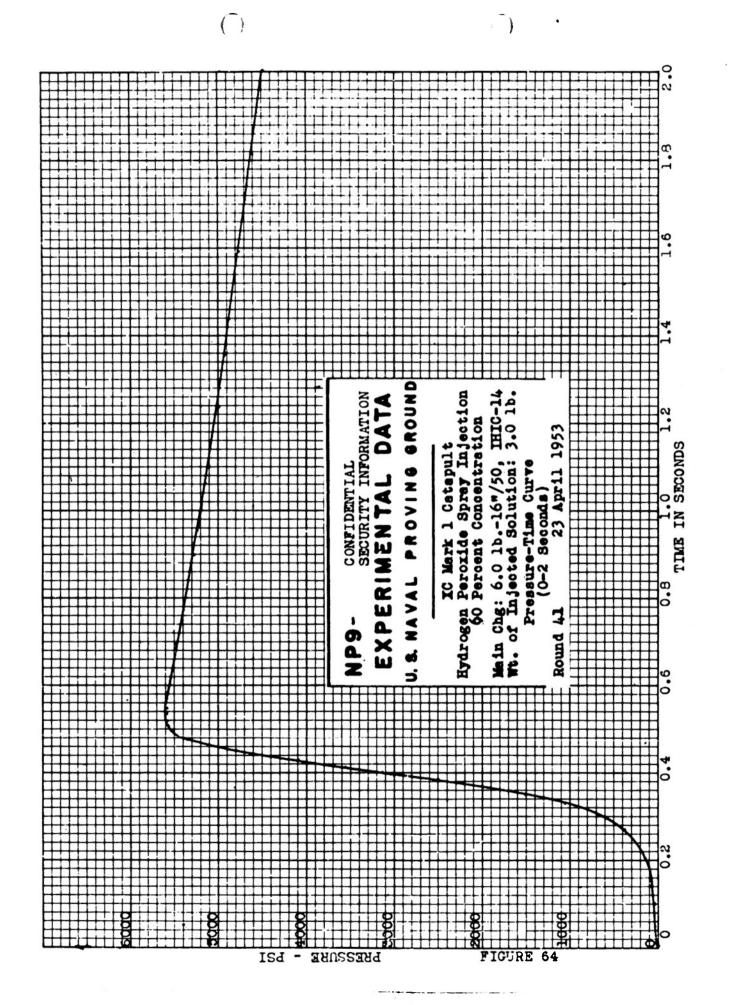


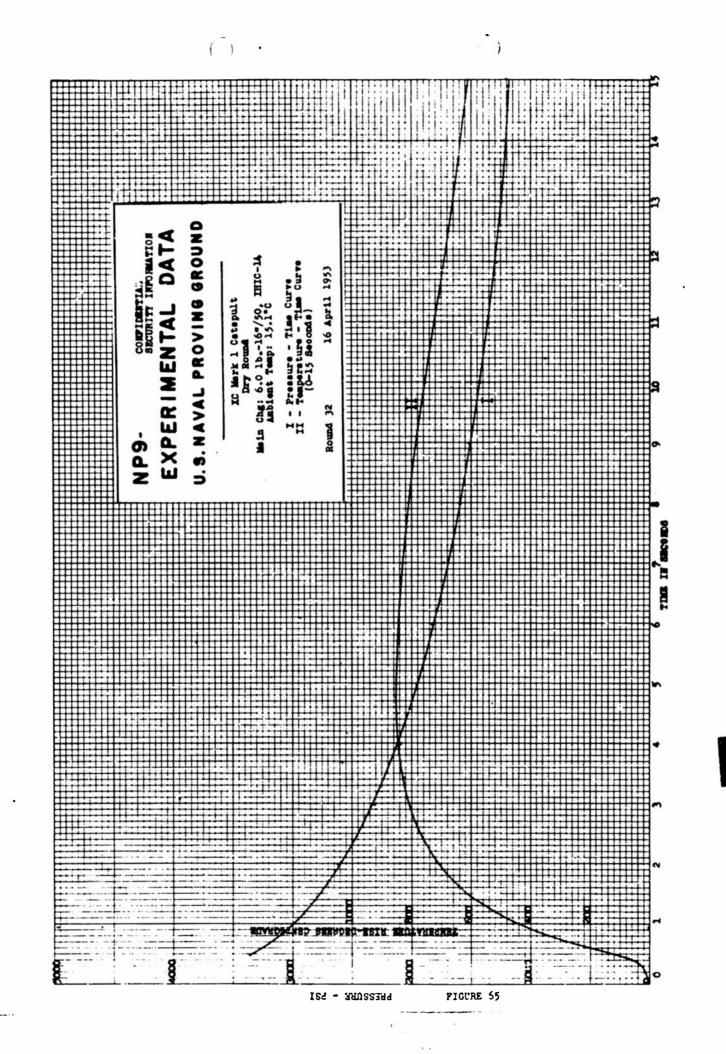


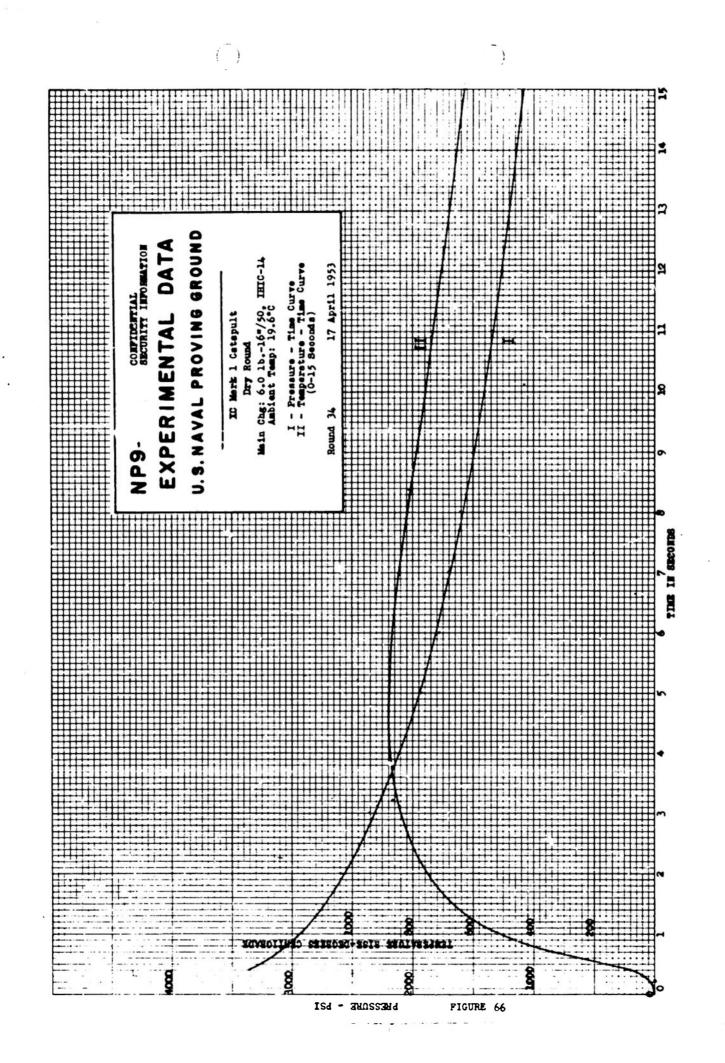


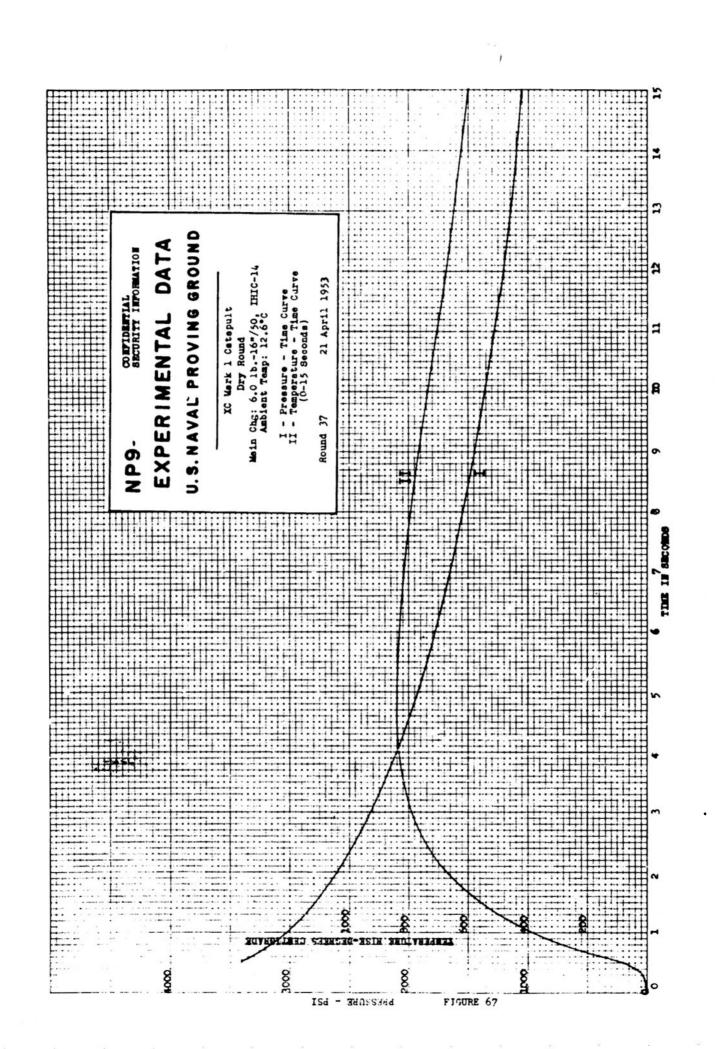


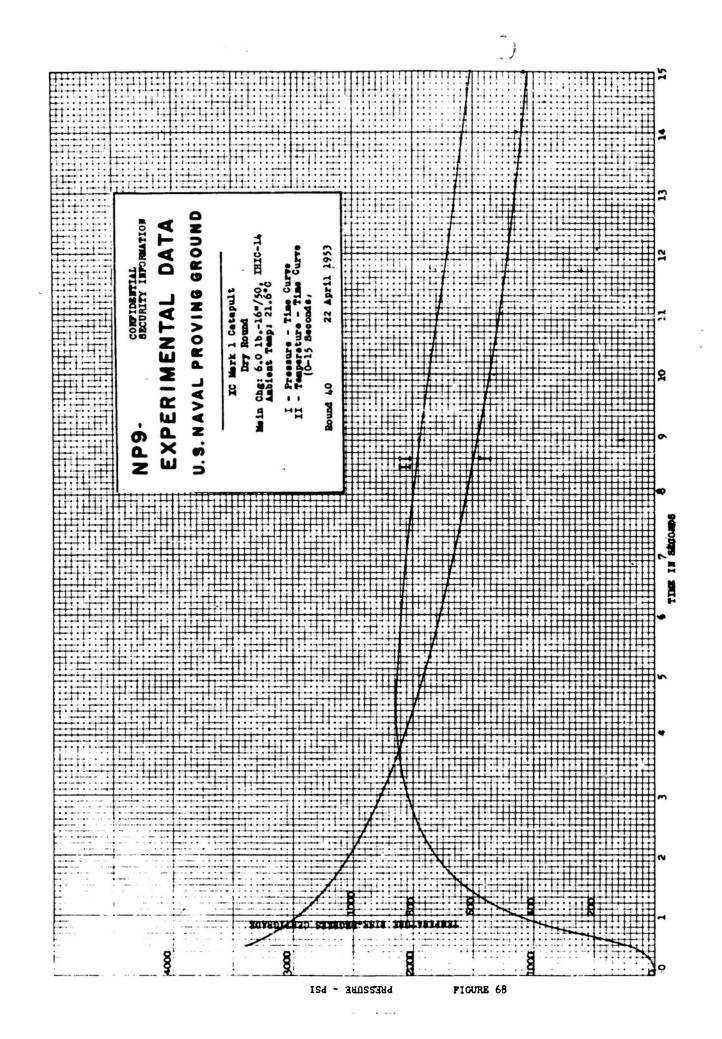


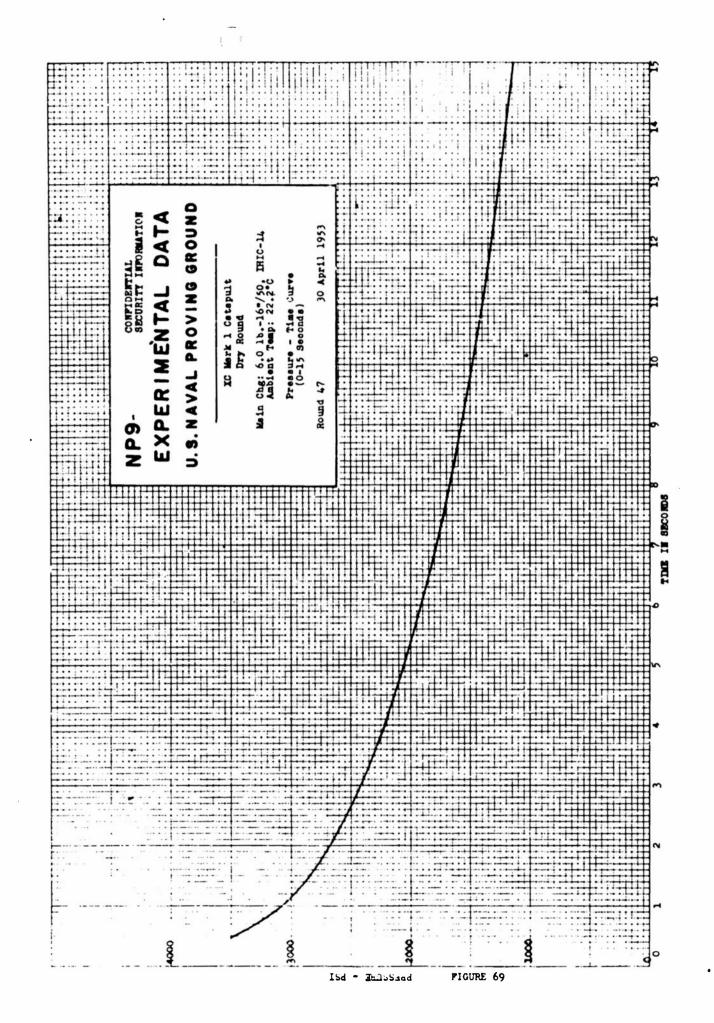












NP9 CONTIDENTIAL INFORMATION SECURITY INFORMATION EXPERIMENTAL DATA U. & MAVAL PROVING GROUND

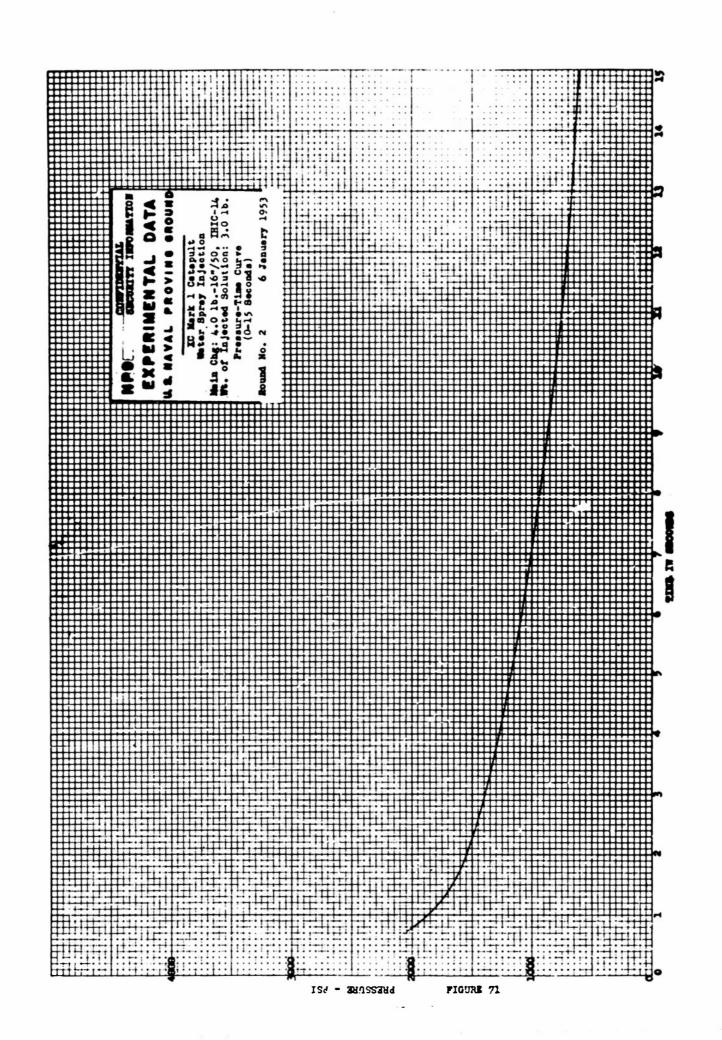
XC Mark 1 Catapult

Wein Chg: 4.0 lb.-16"/5c, IHIC-14

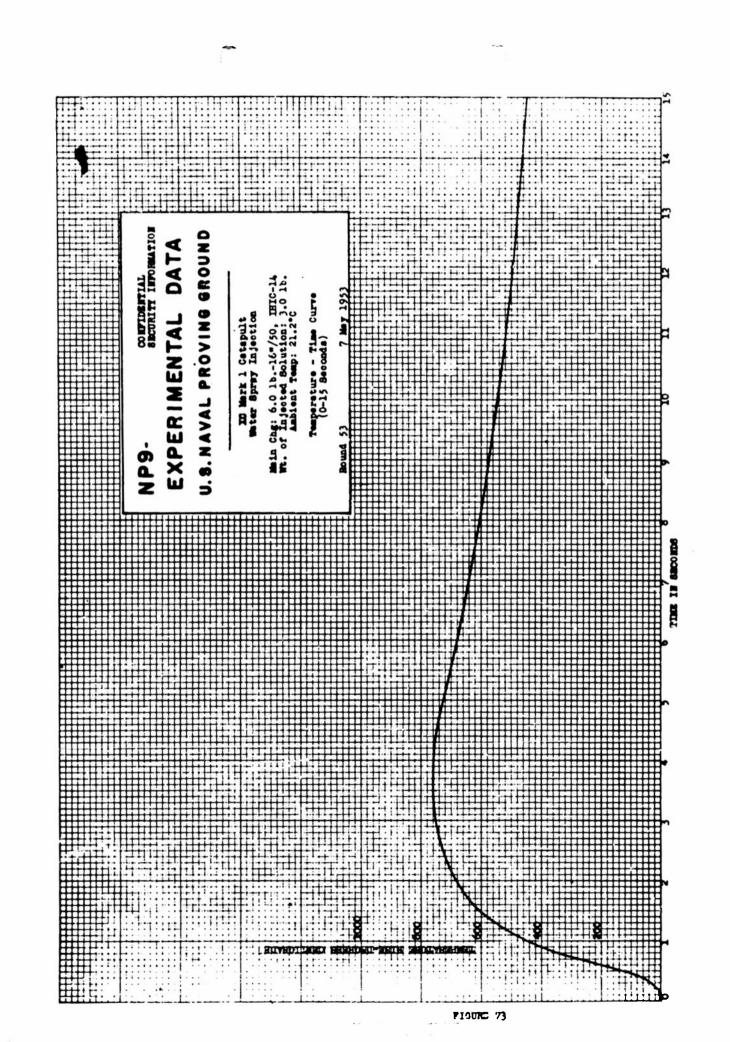
Wt. of Injected Sclution: 3.0 lb.

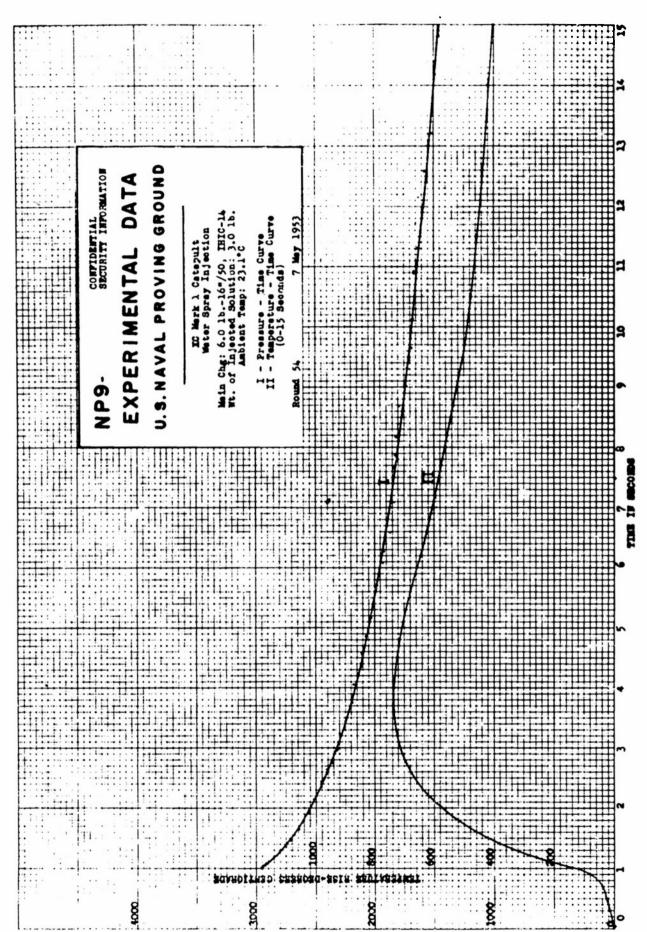
Pressure-Time Curve

(0-15 Se: onds) 5 Jenuery 1953 PRESSURE - PSI FIGURE 70

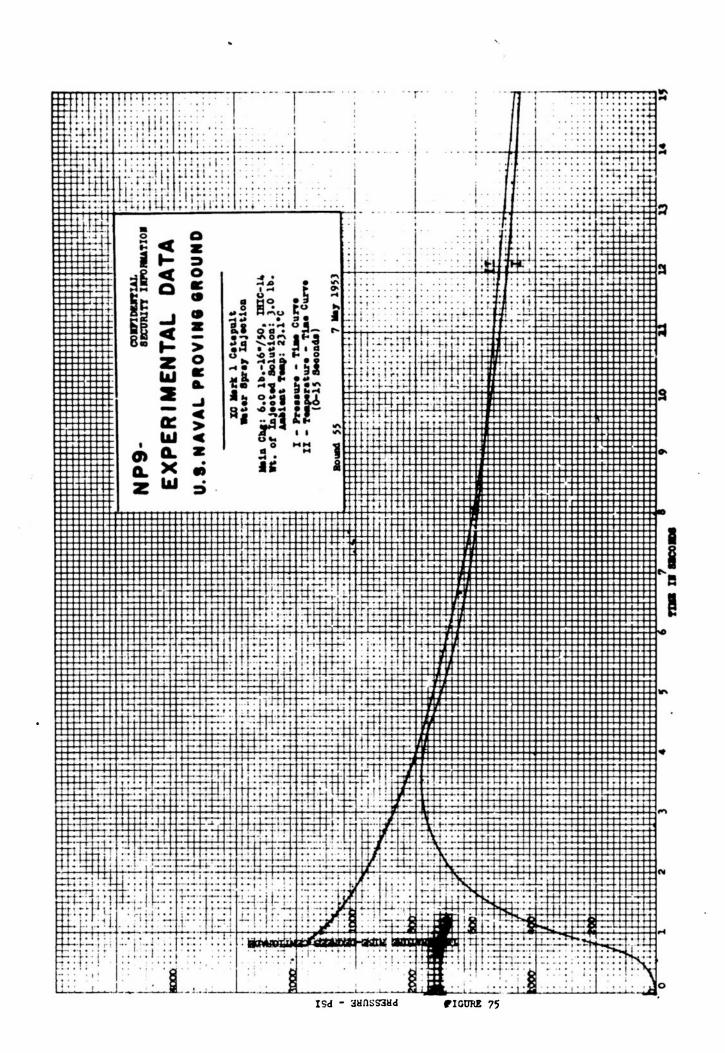


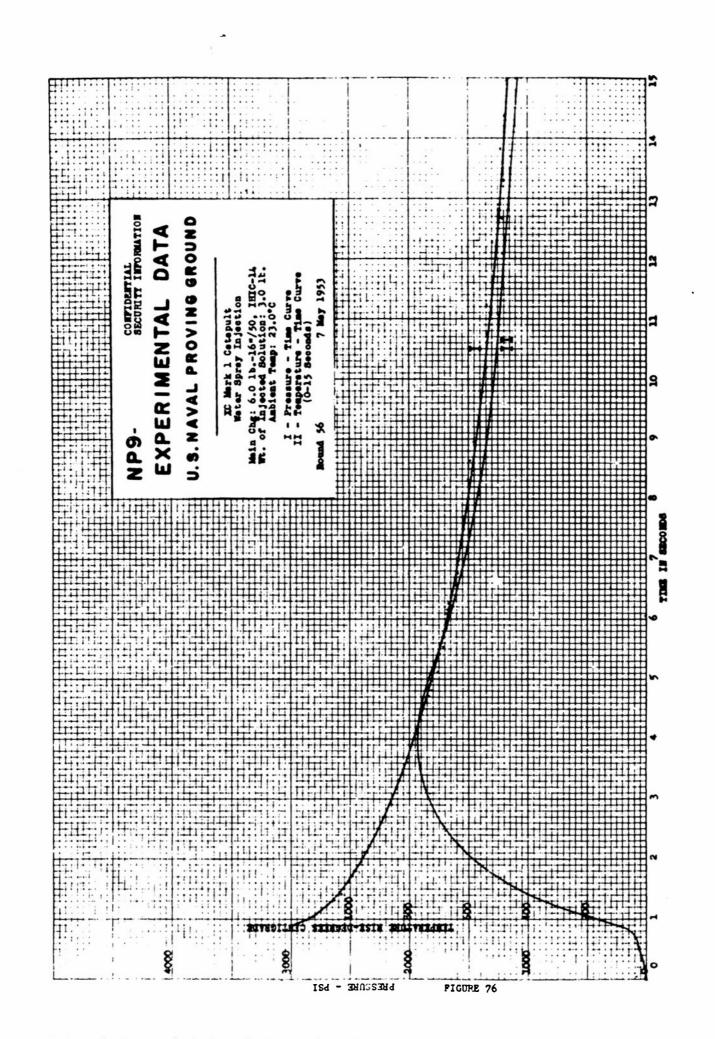
U. S. MAVAL PROVING GROUND EXPERIMENTAL DATA Moter Sprey Injection PRESSURE . PSI FIGURE 72

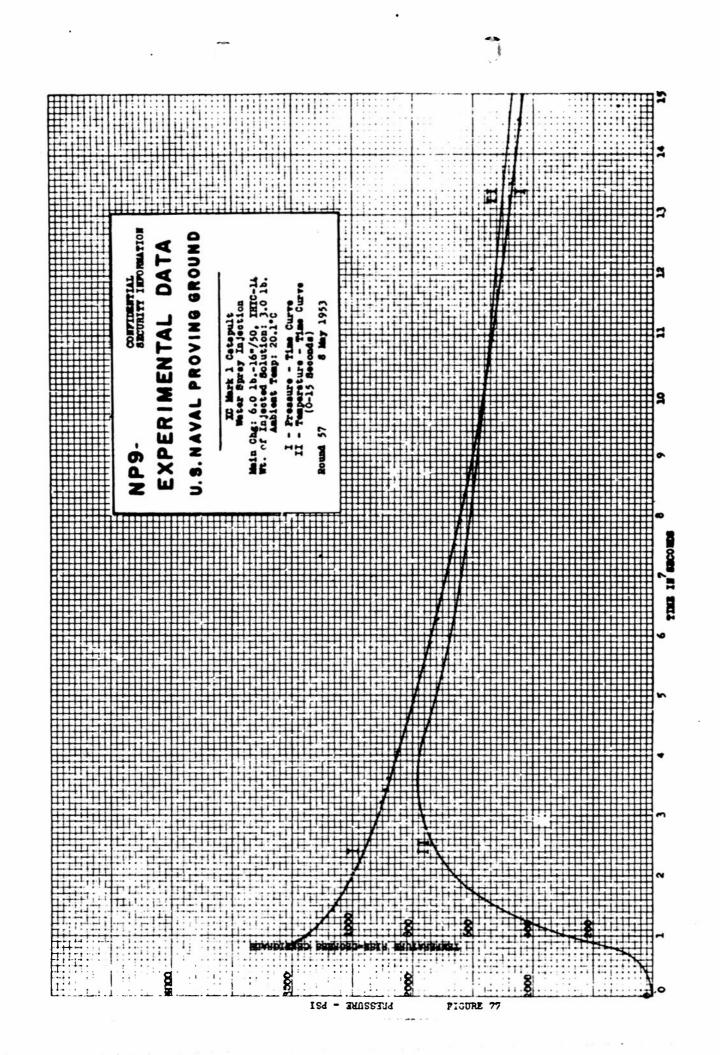


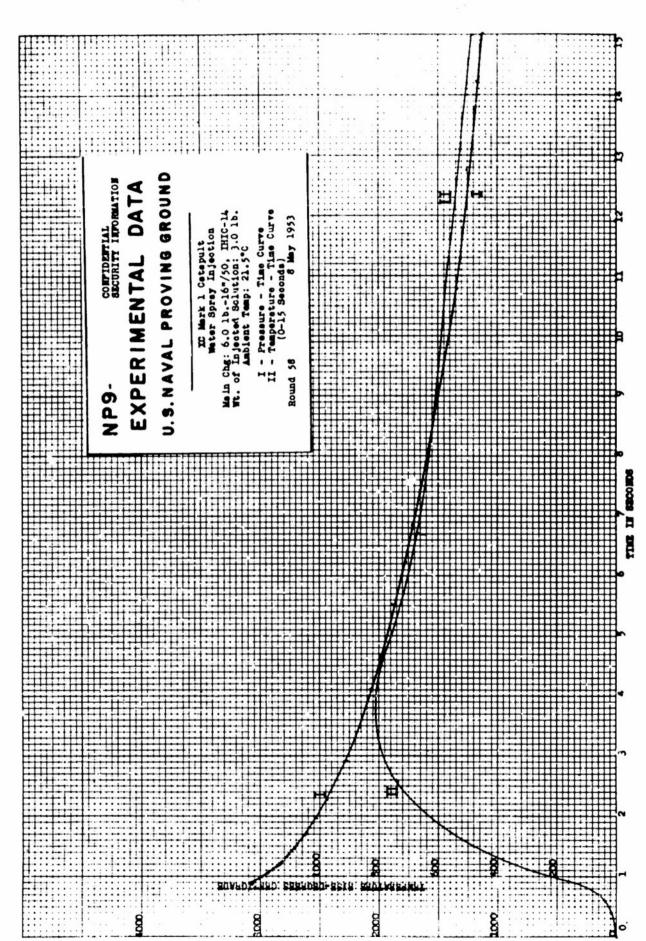


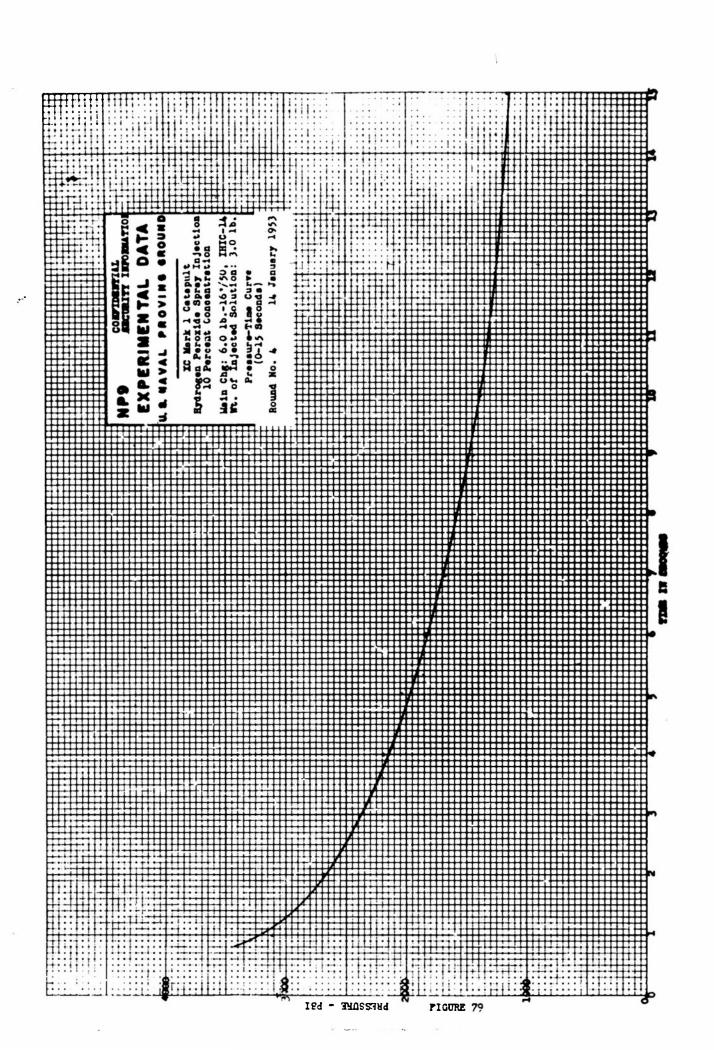
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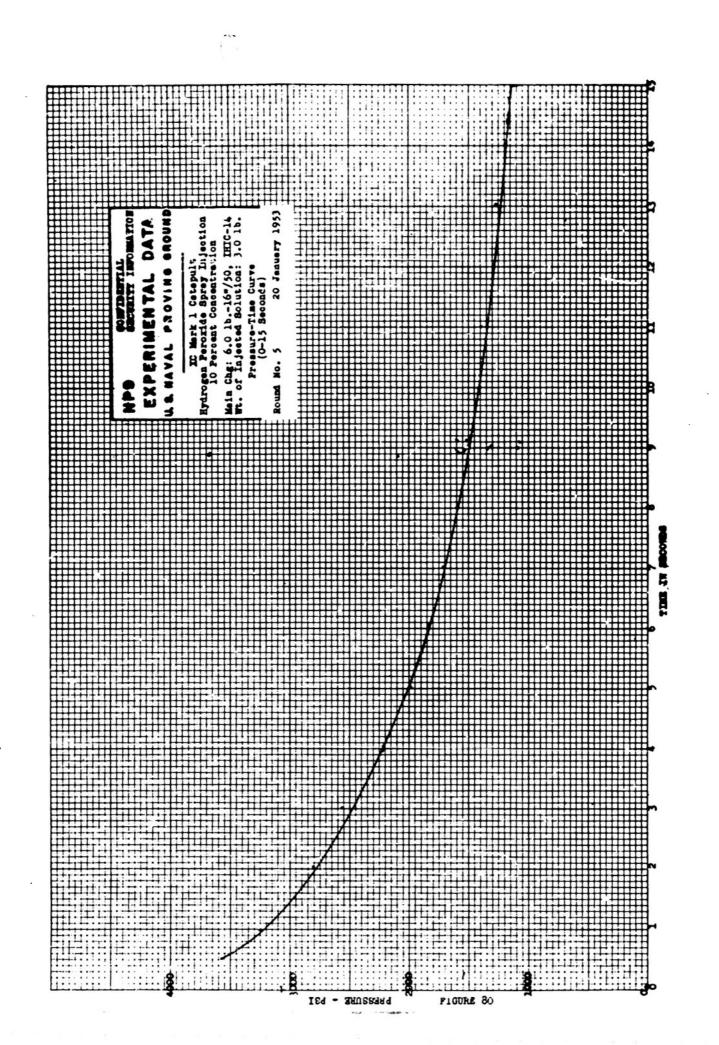


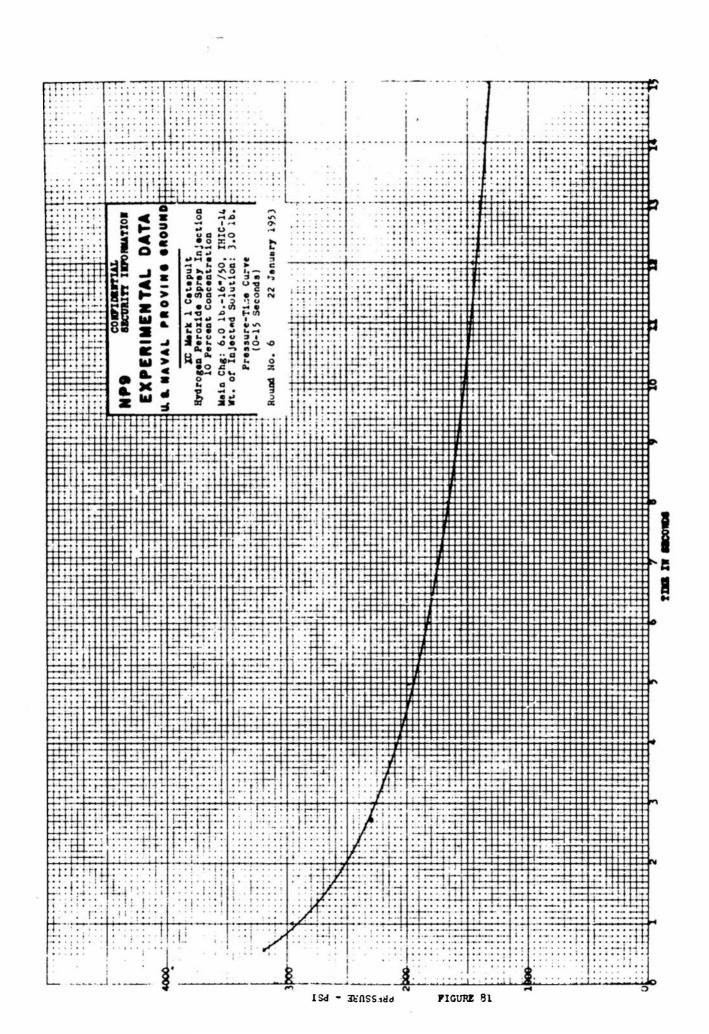


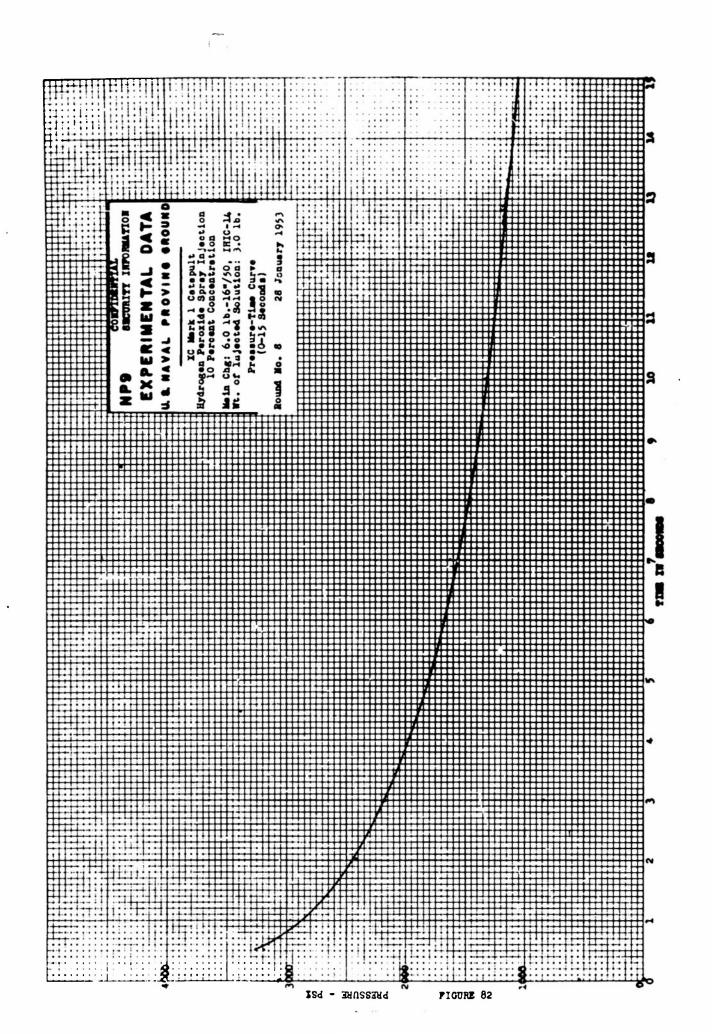


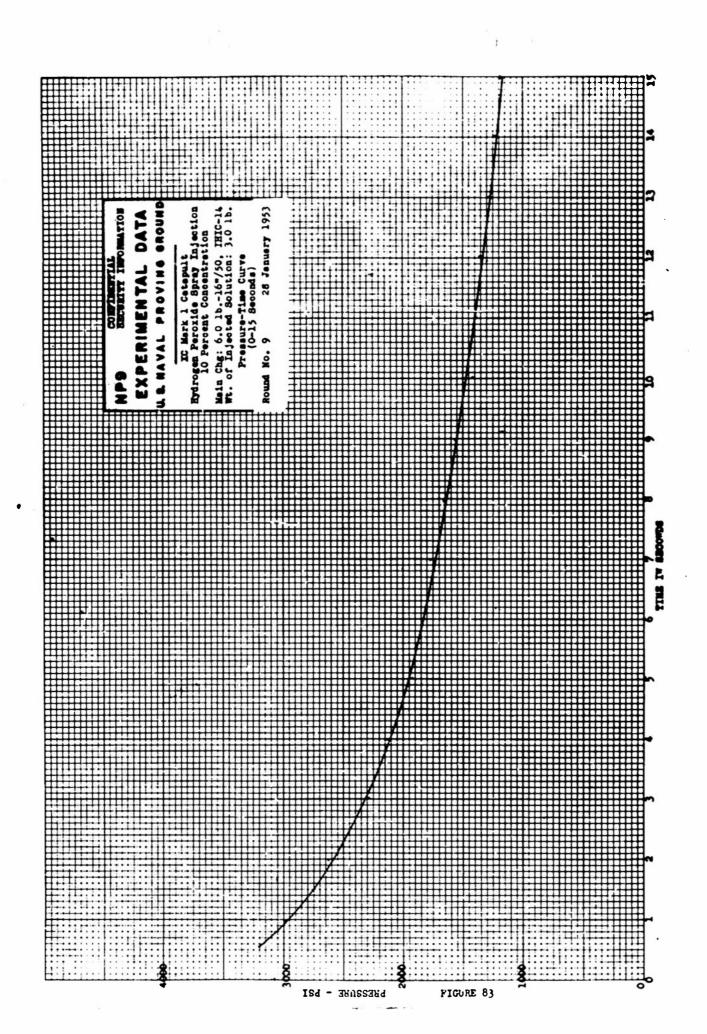


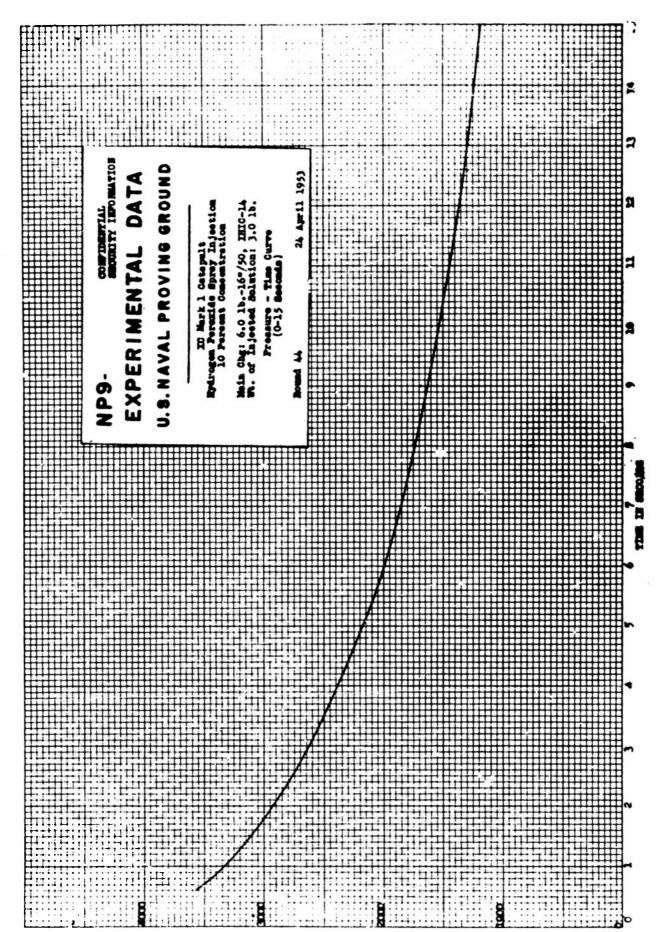


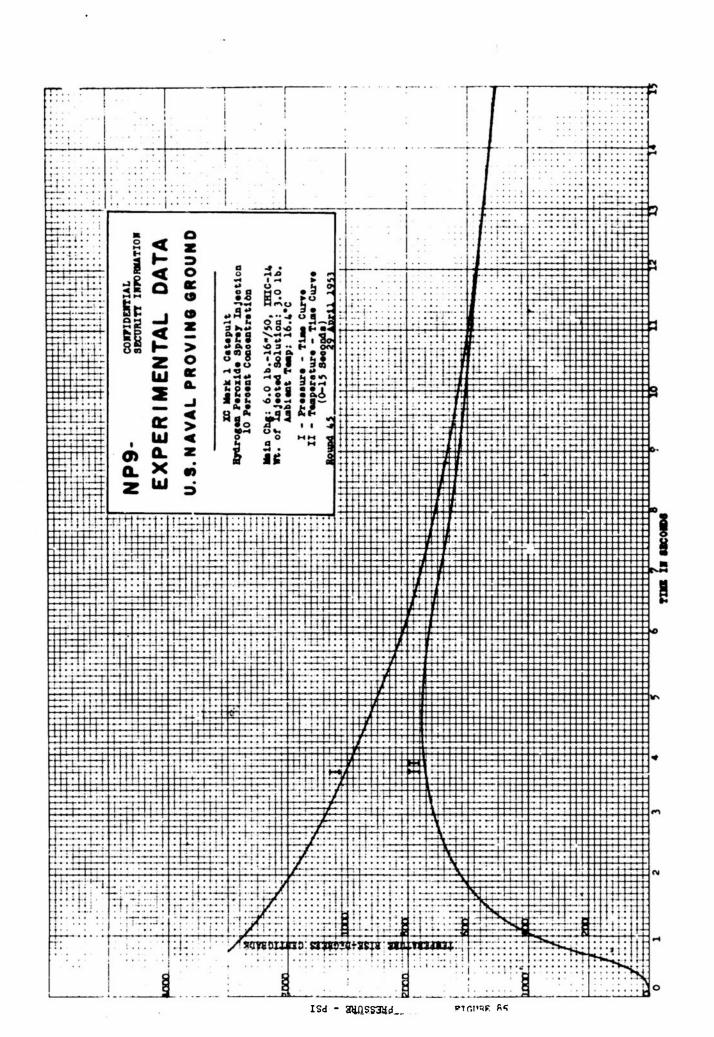


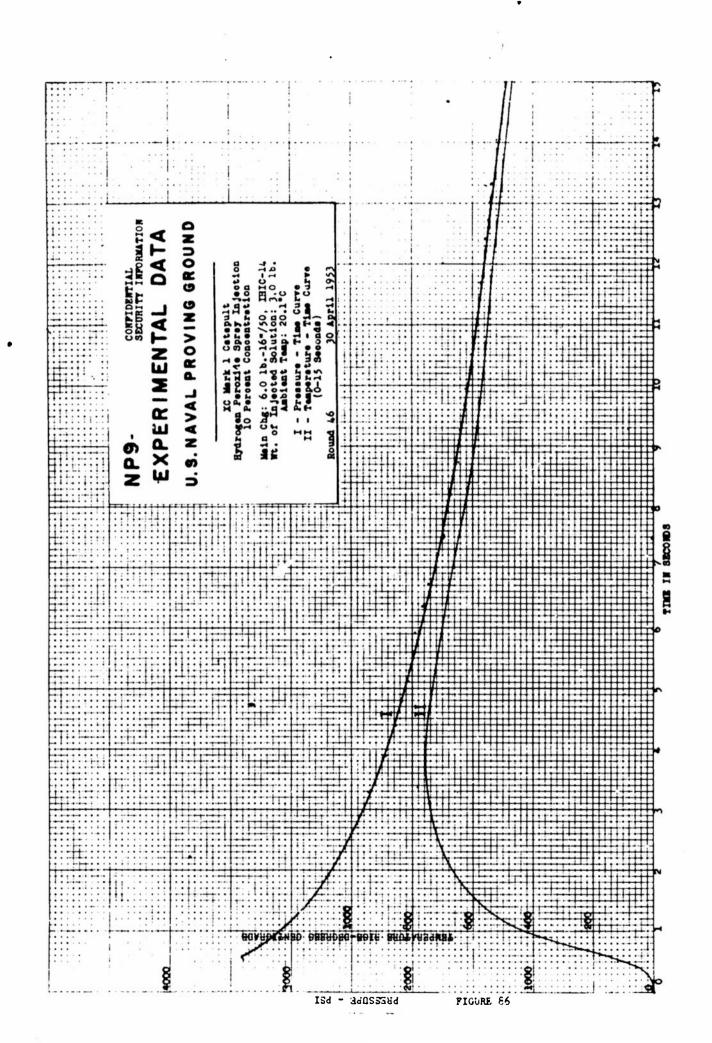


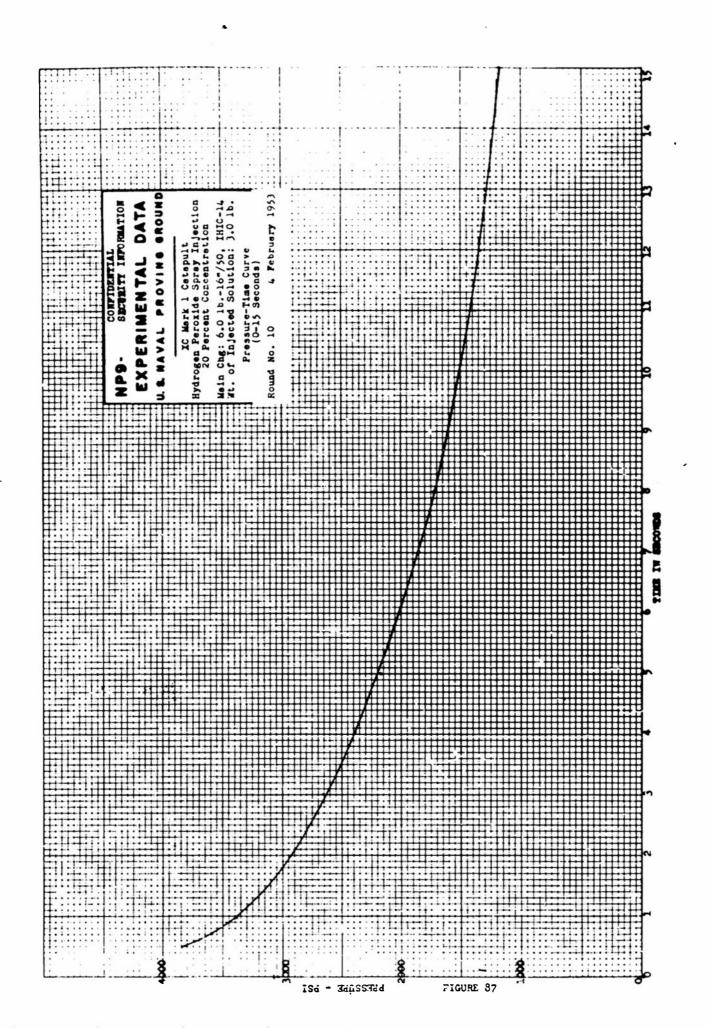


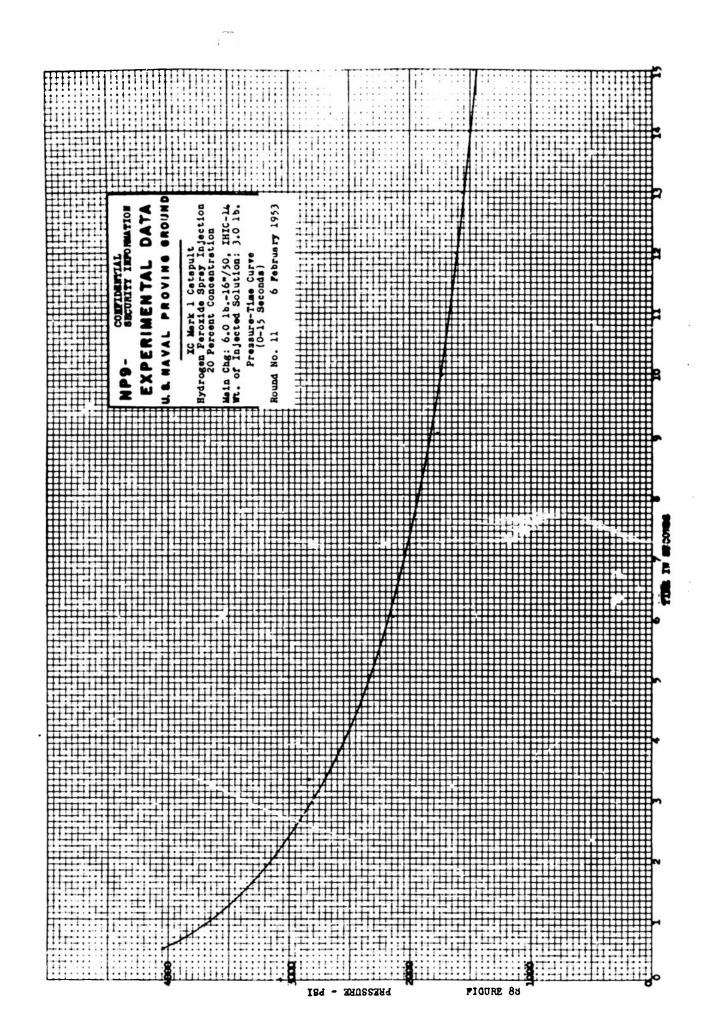


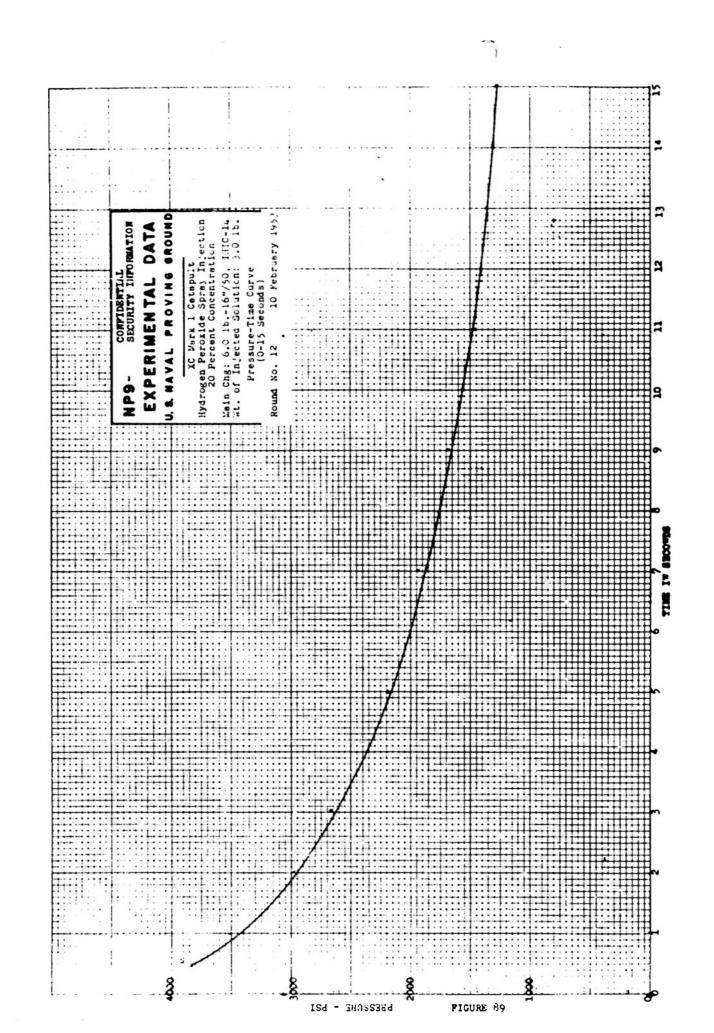


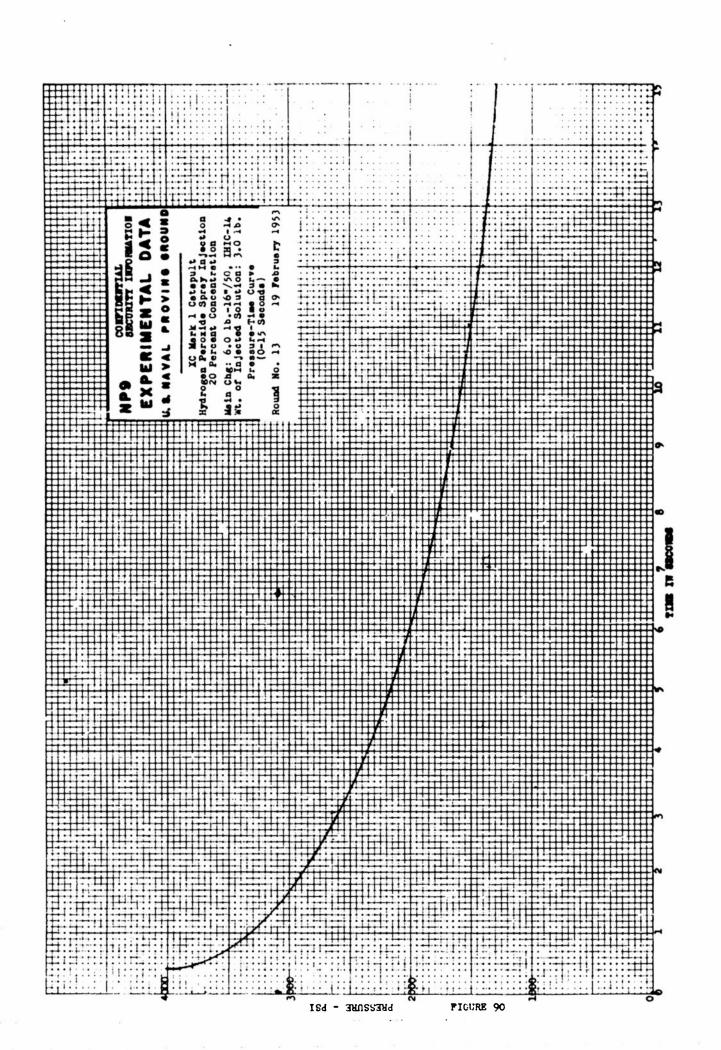


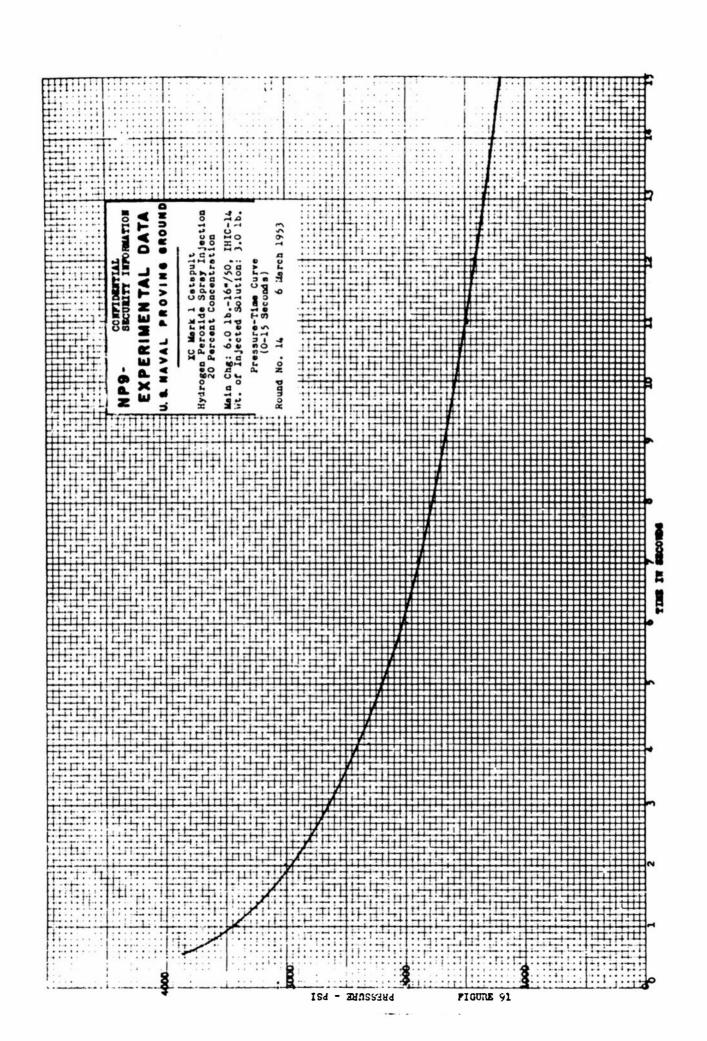


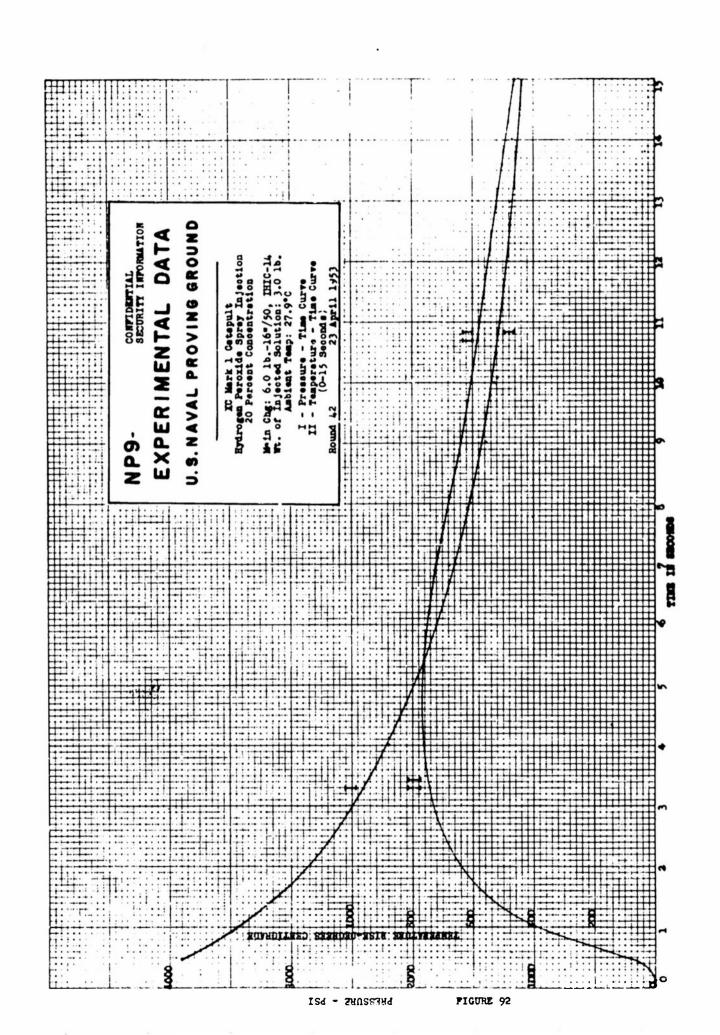


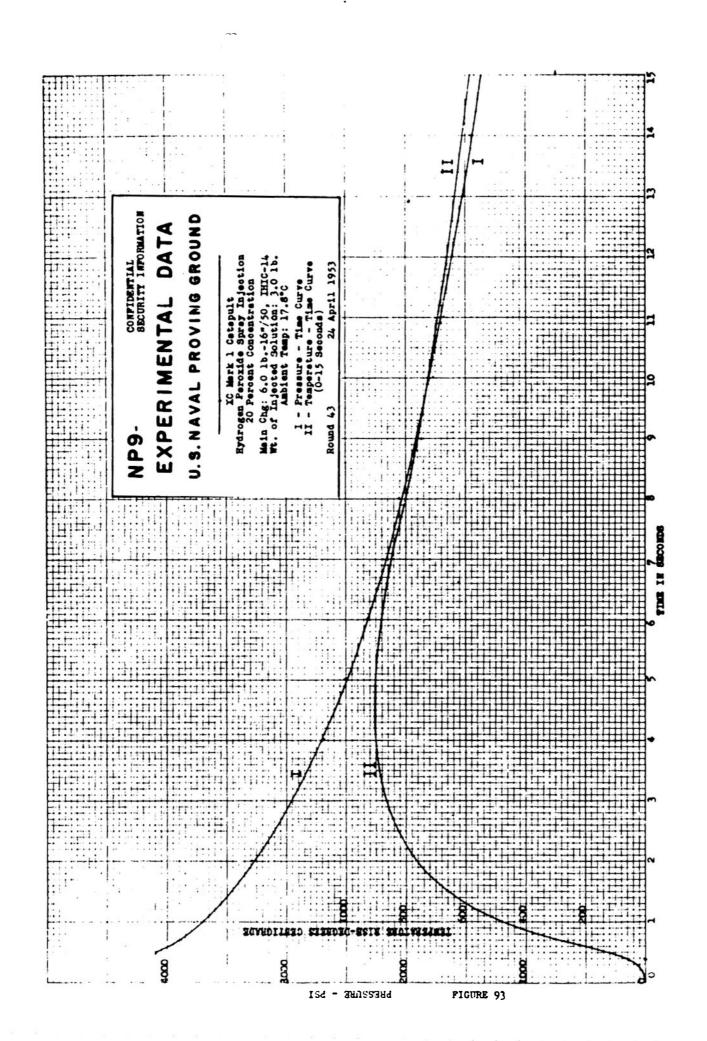


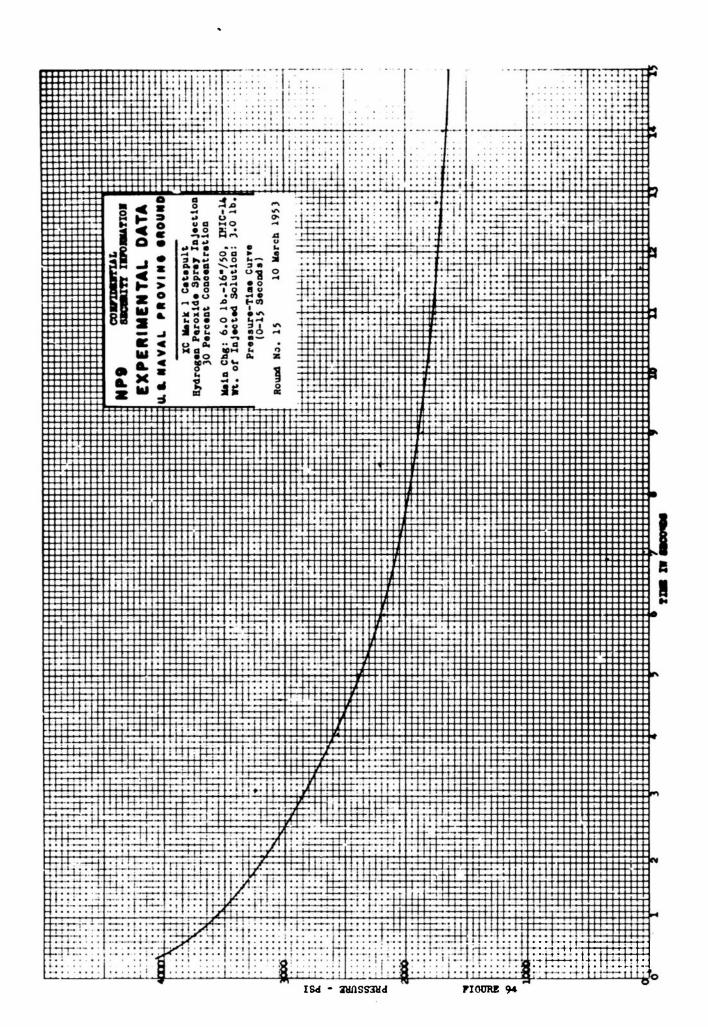


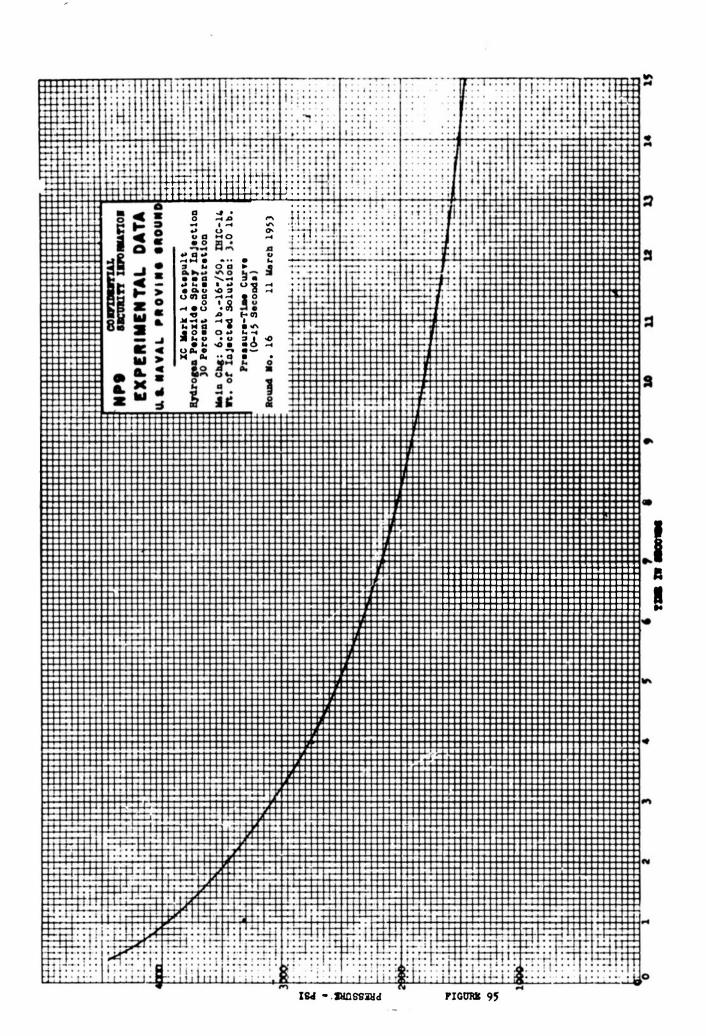


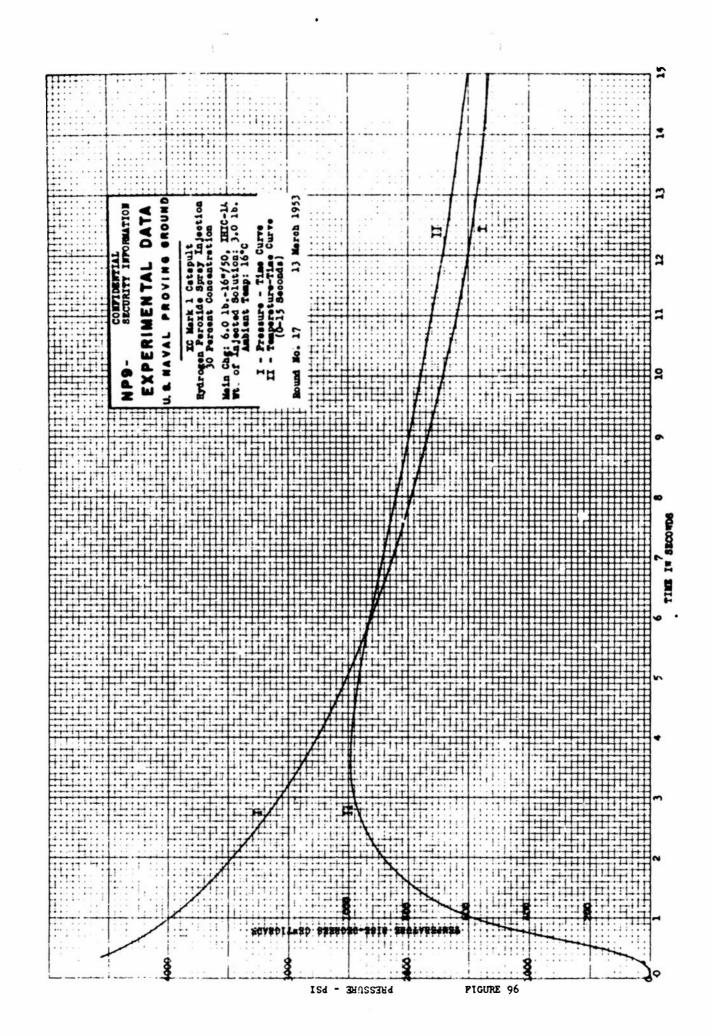


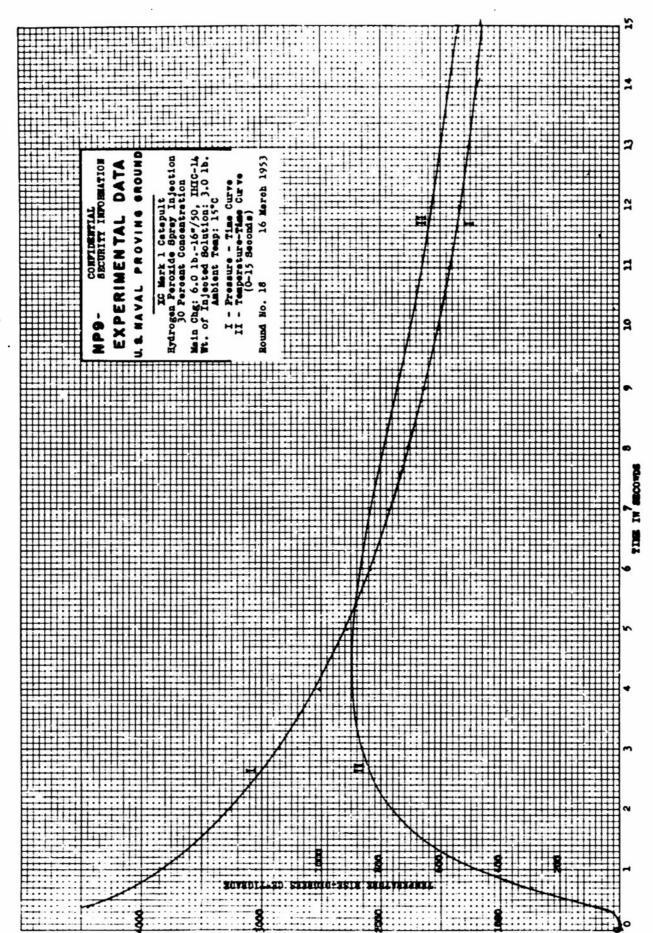


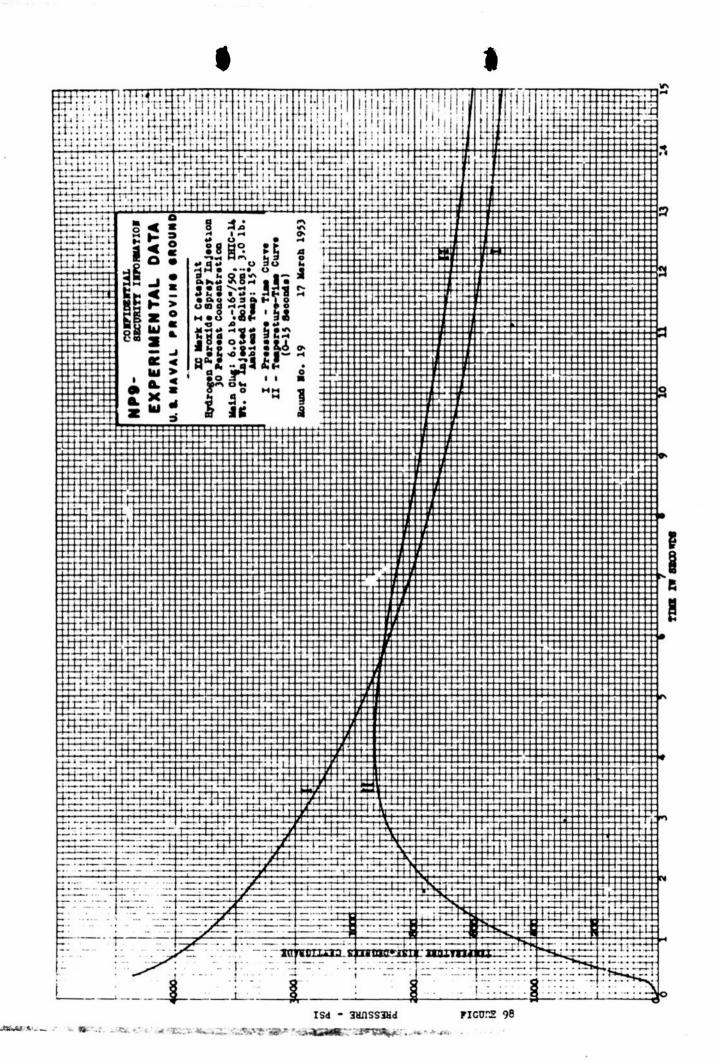


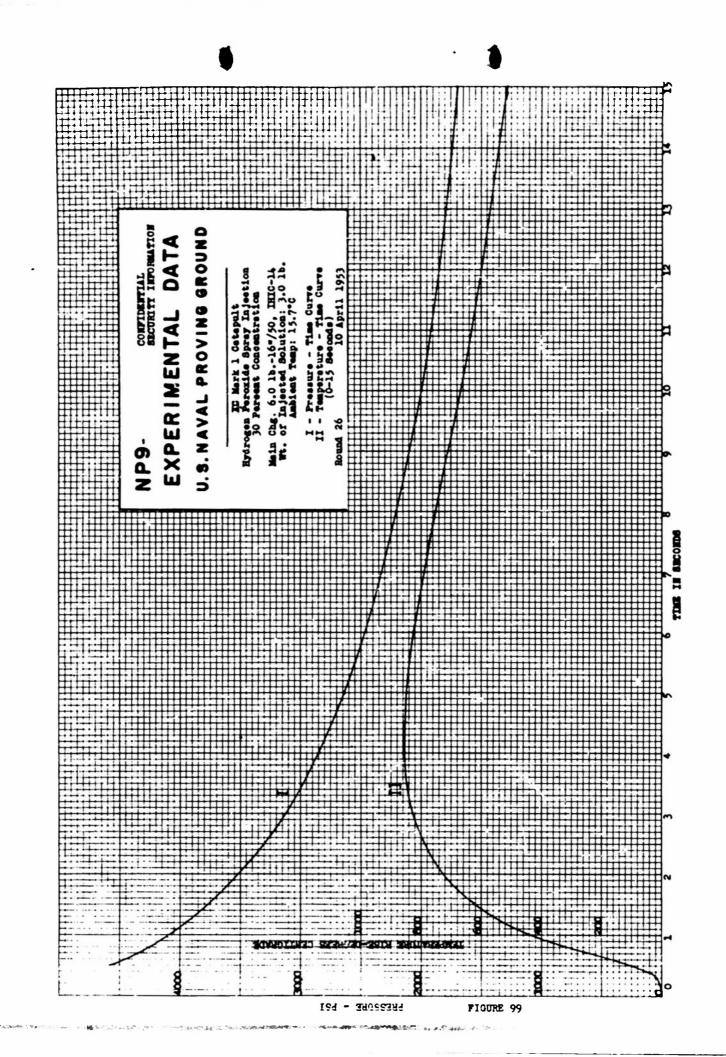


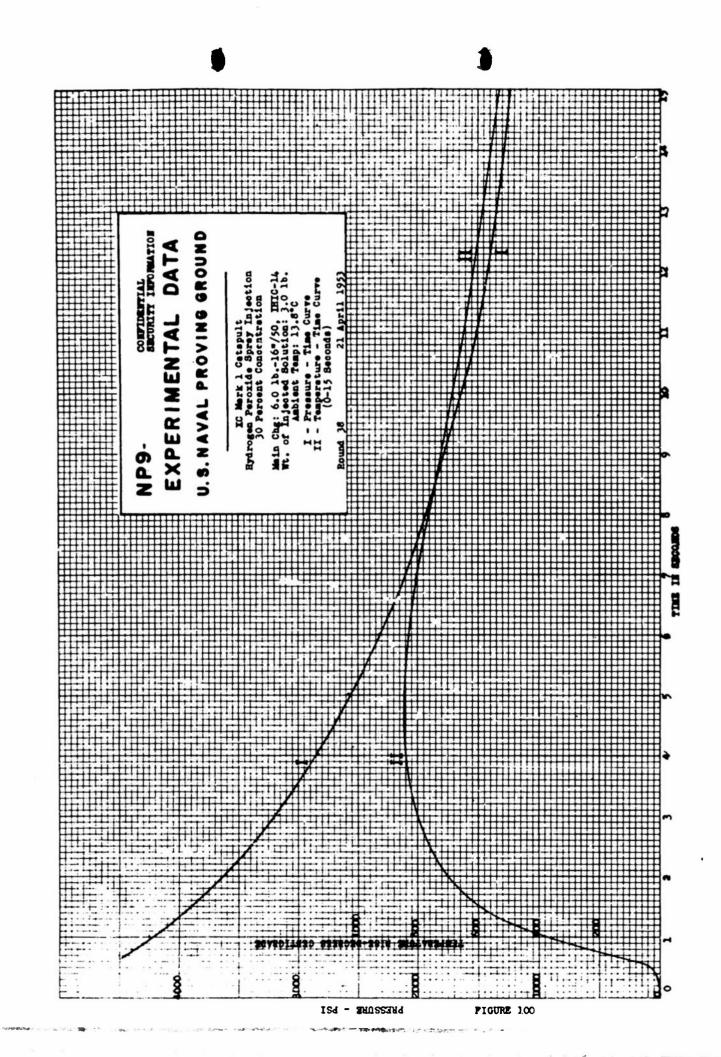


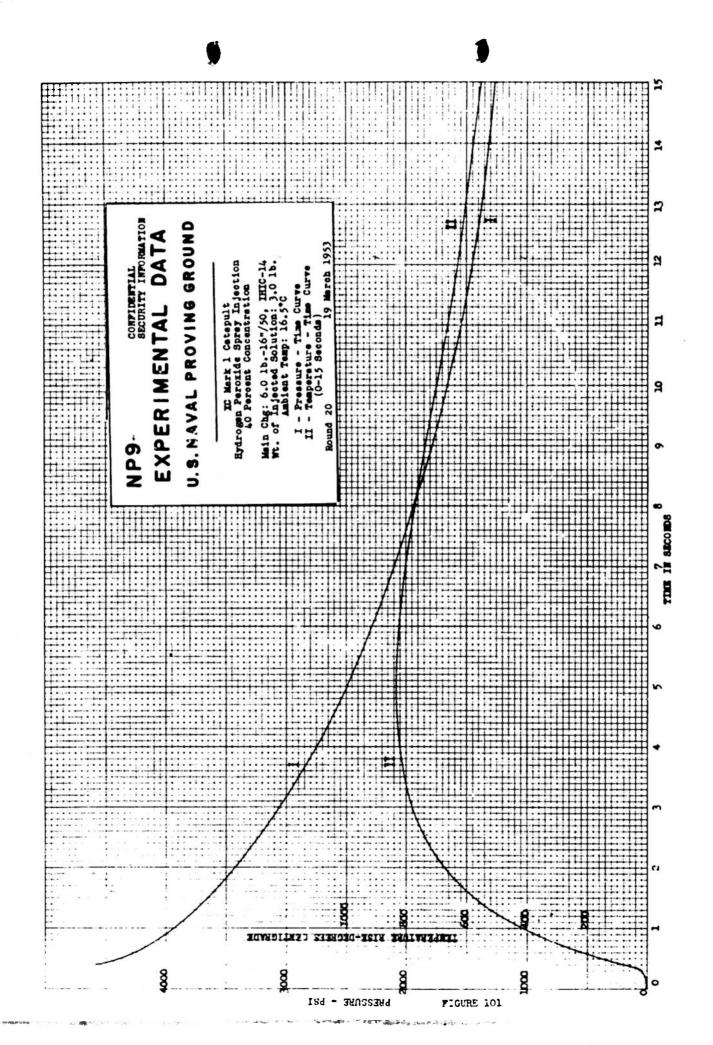


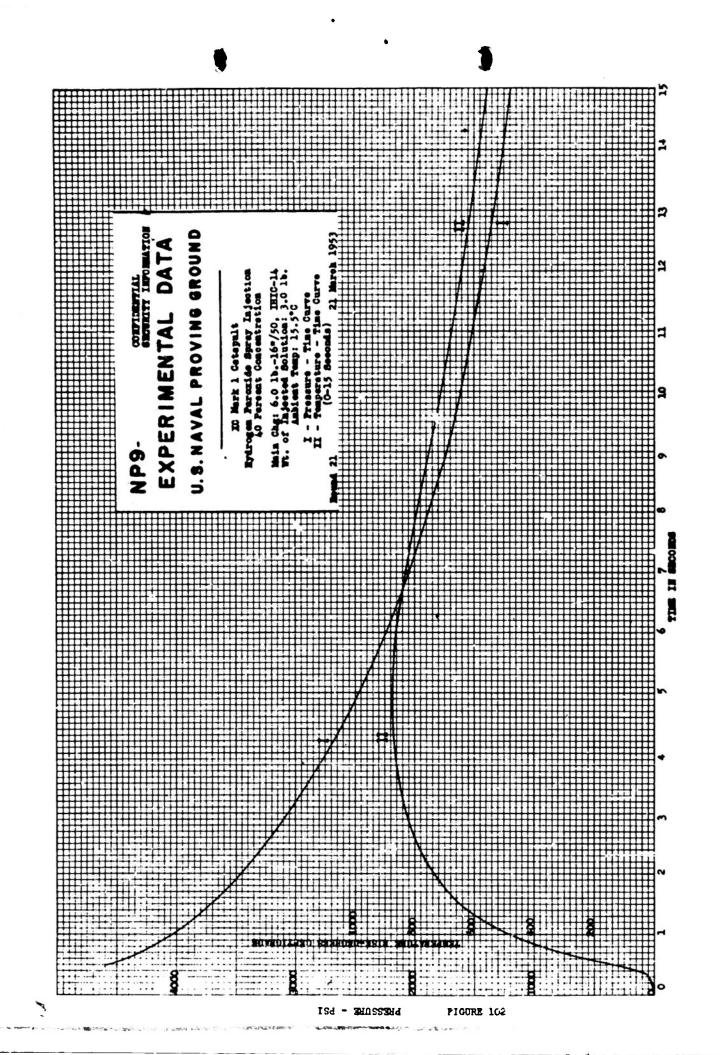


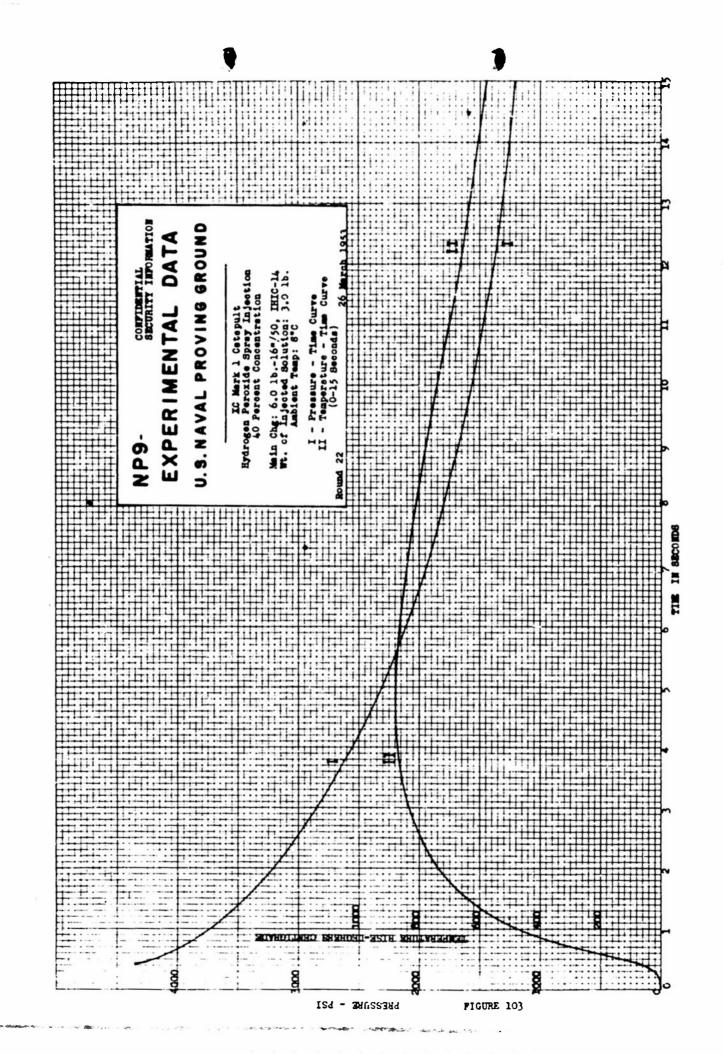


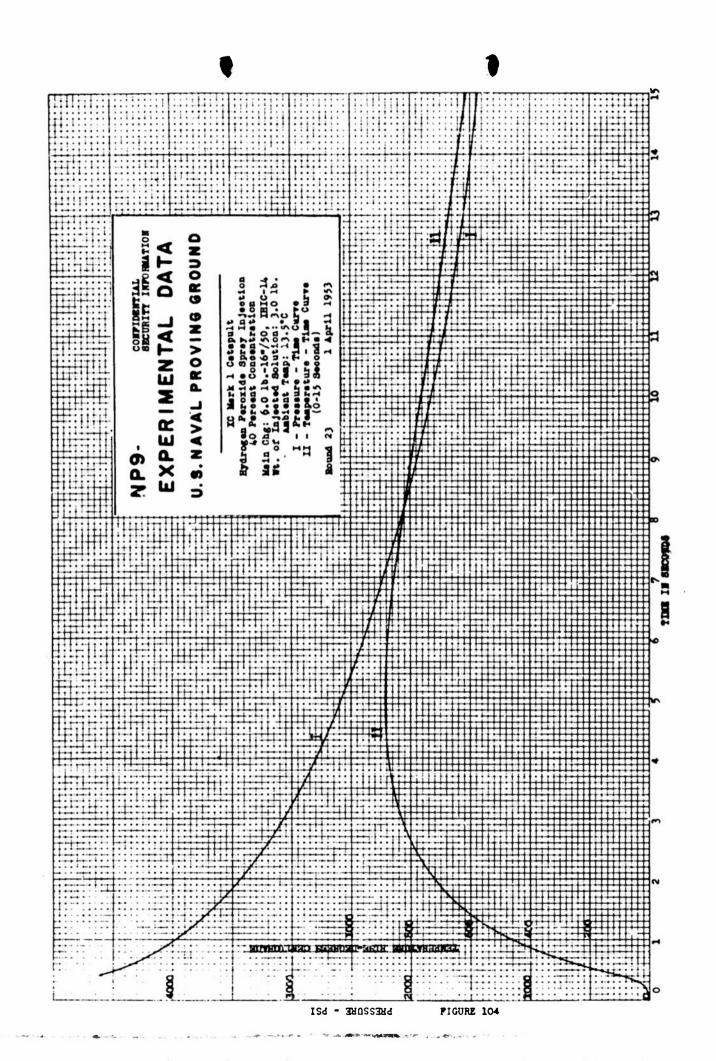




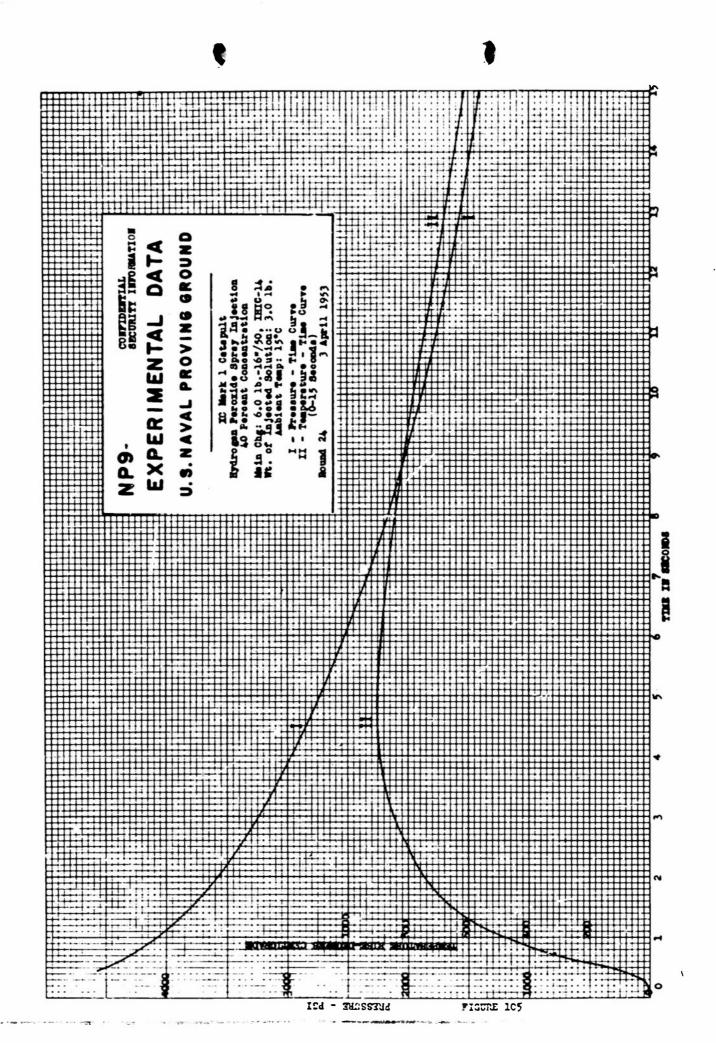


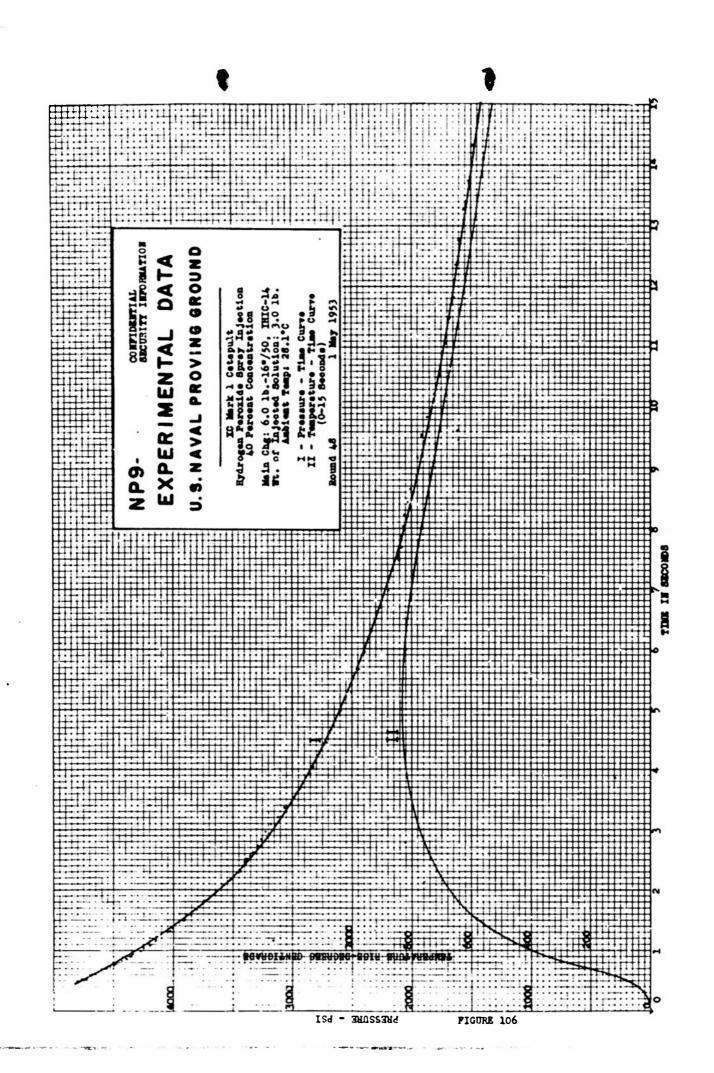


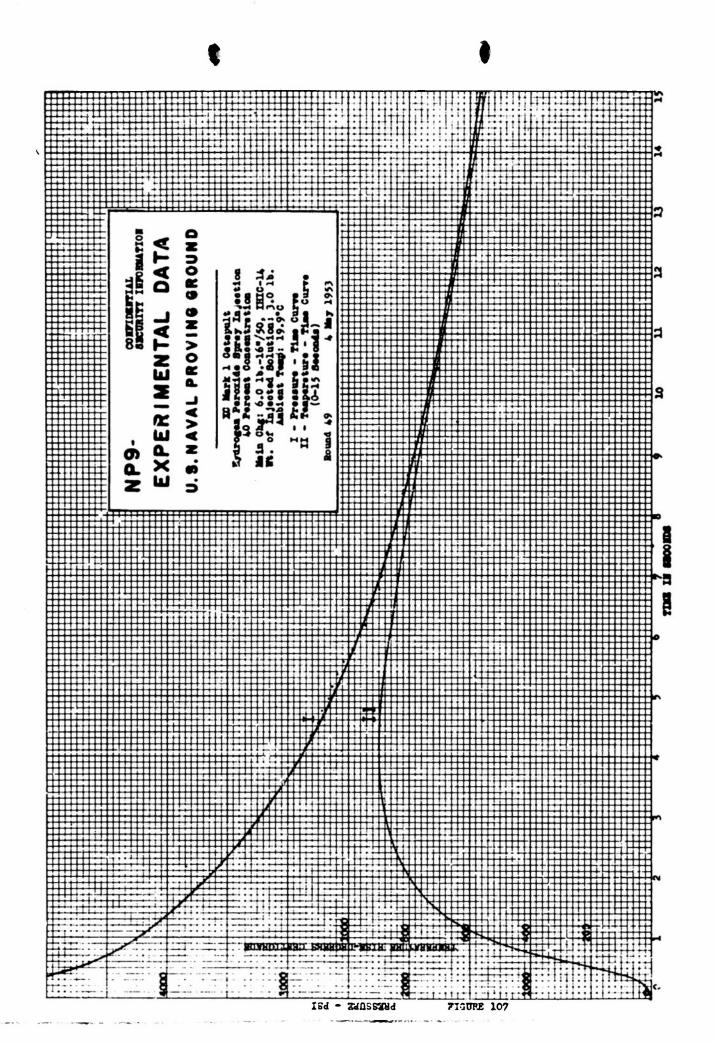


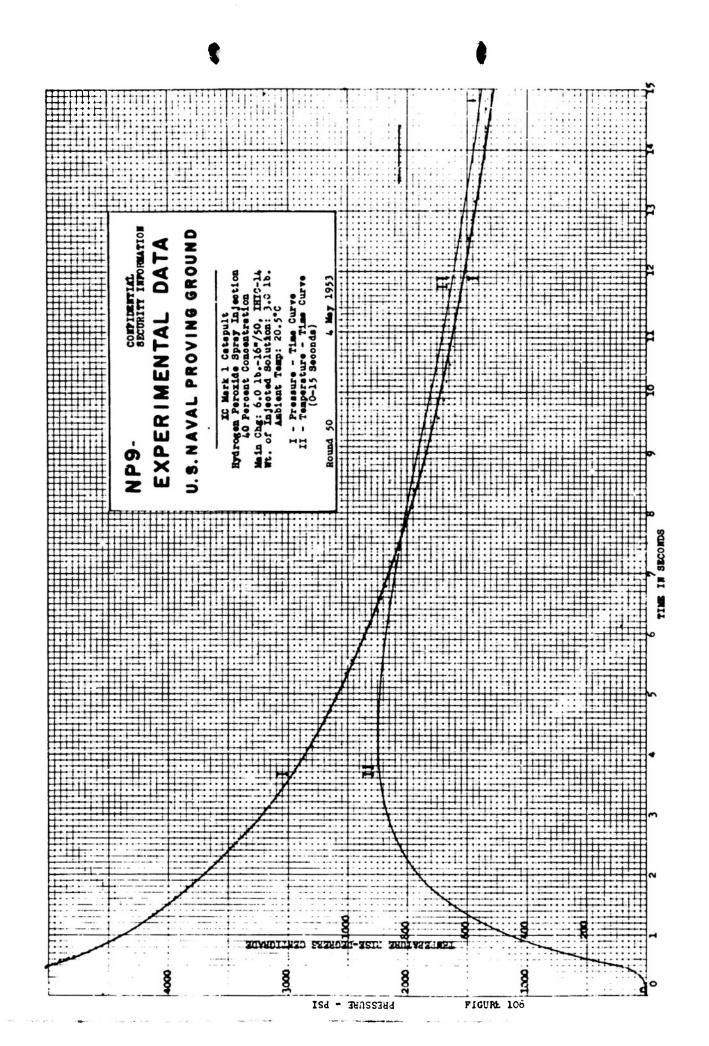


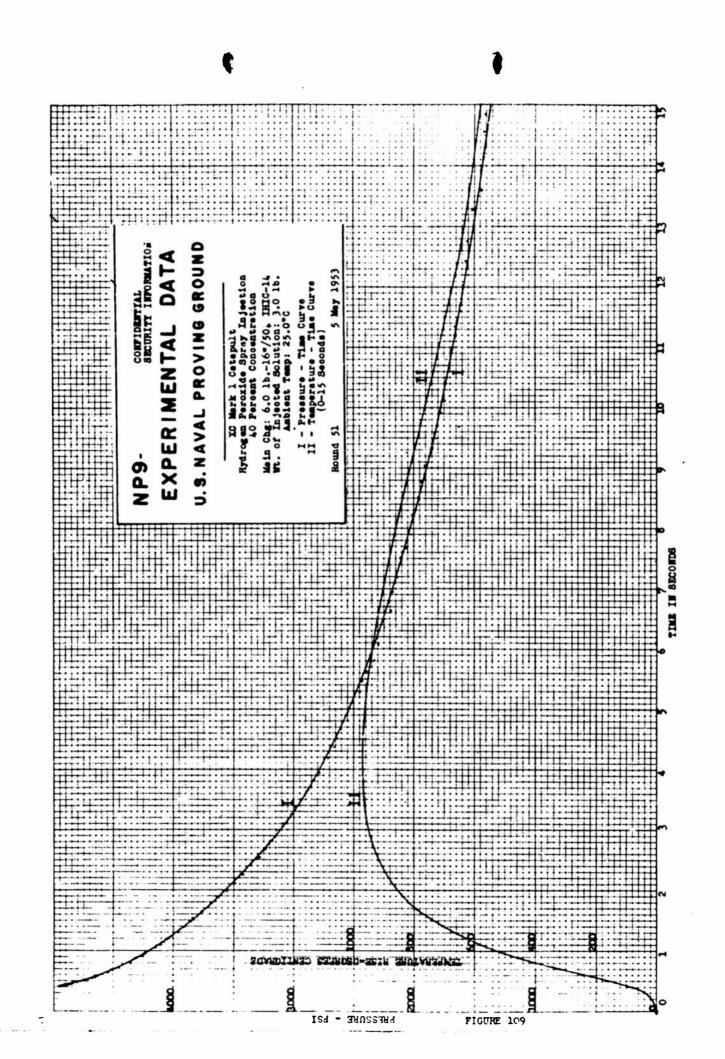
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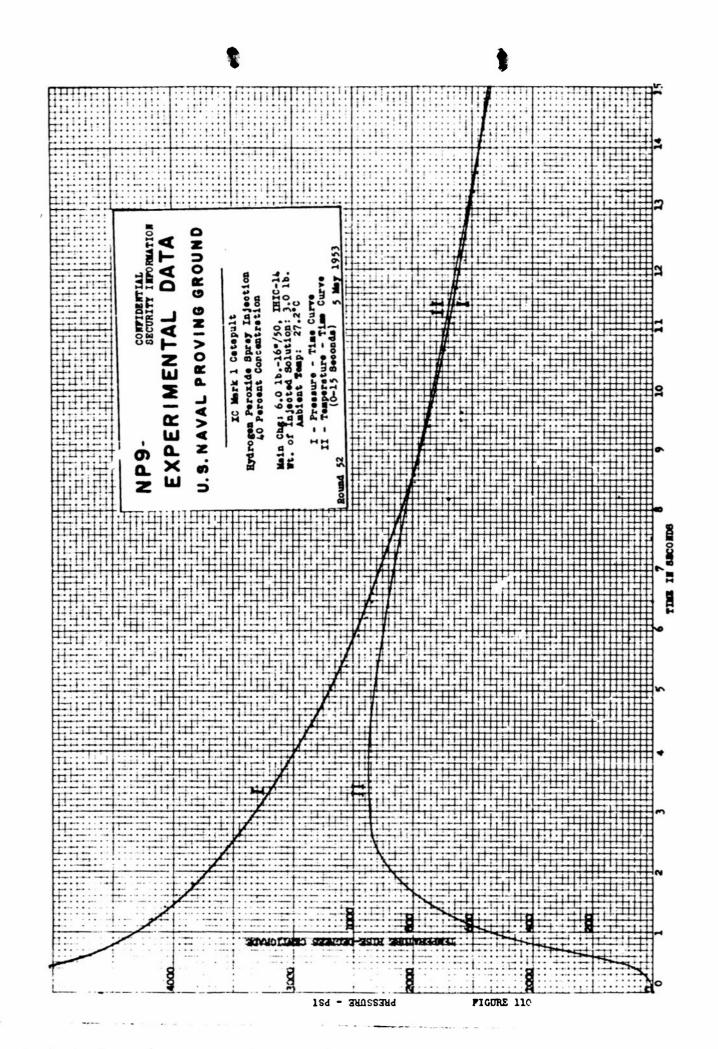


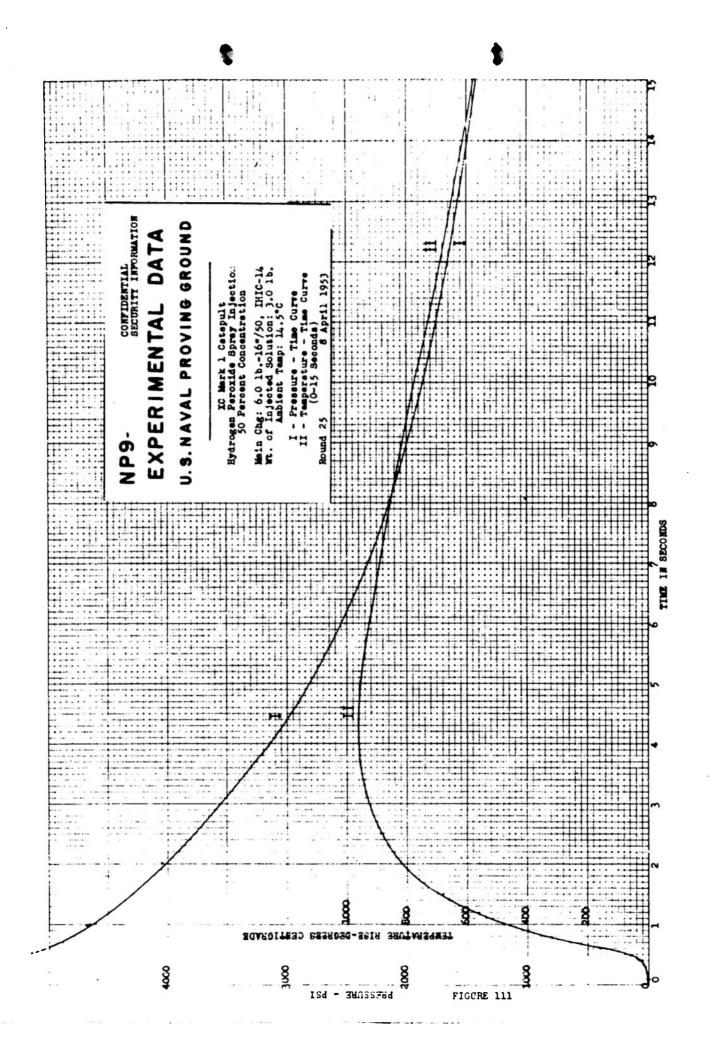


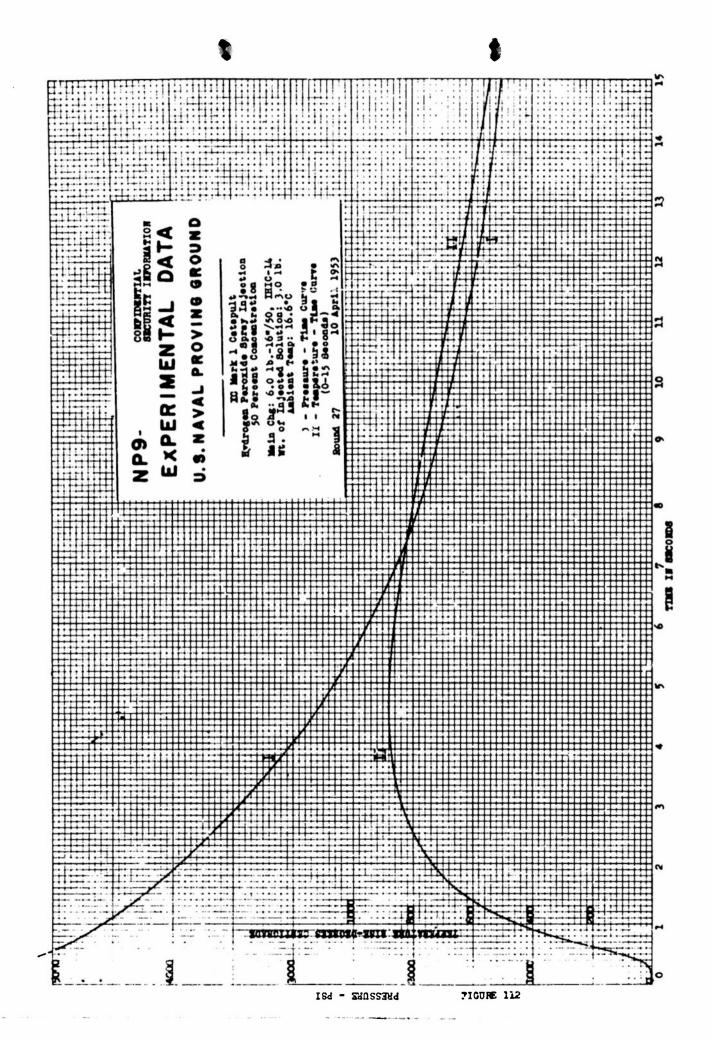


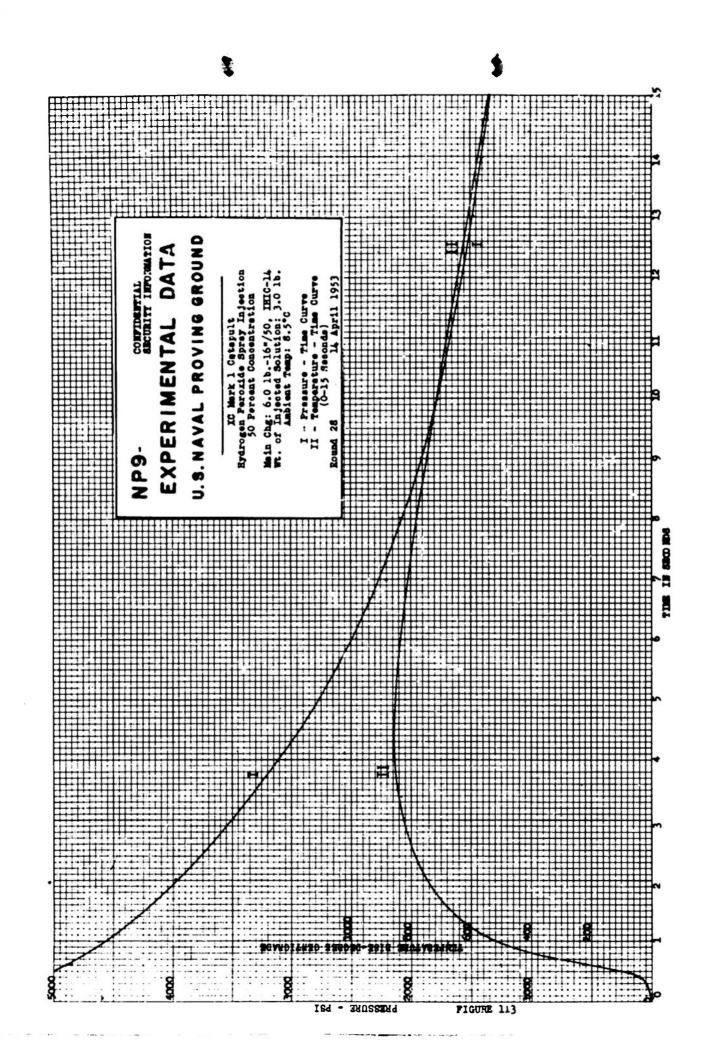


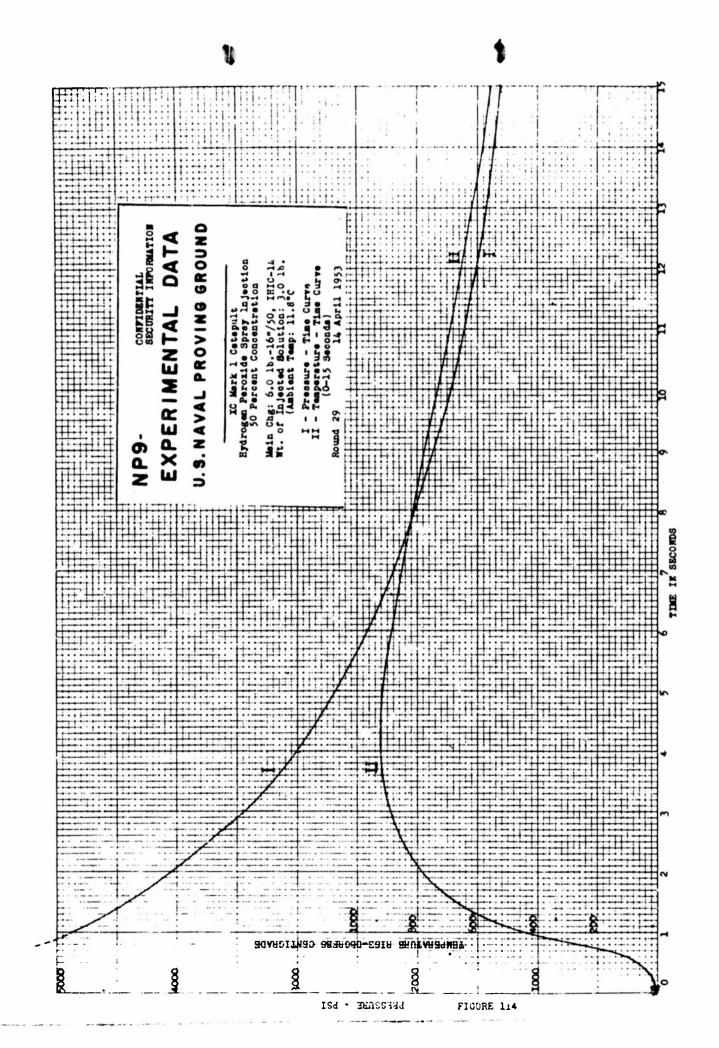


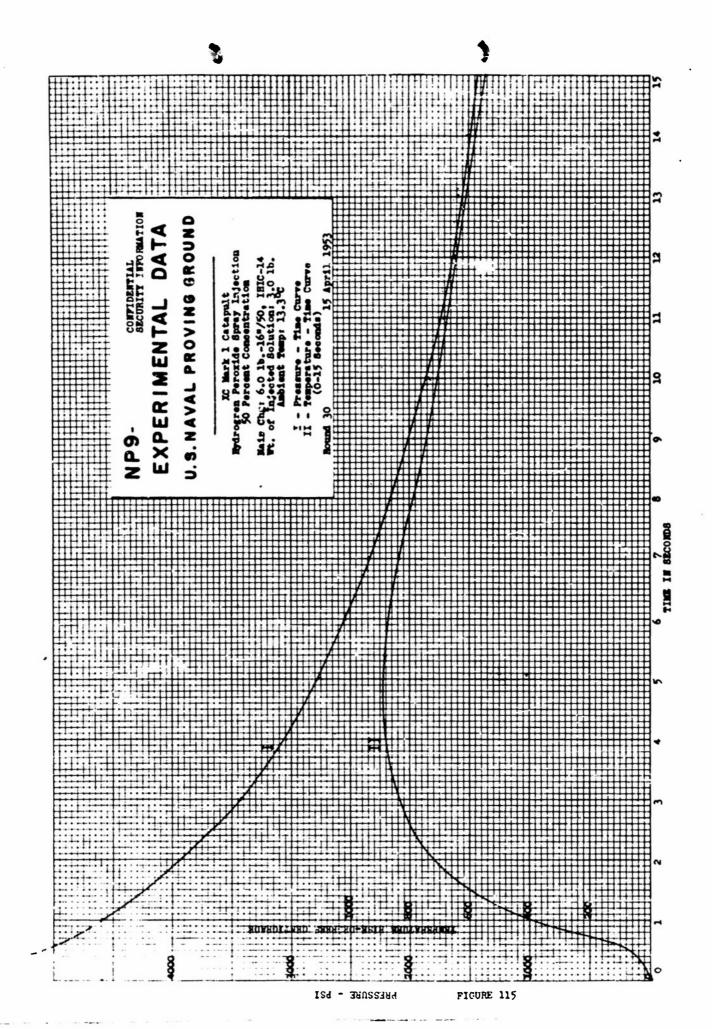


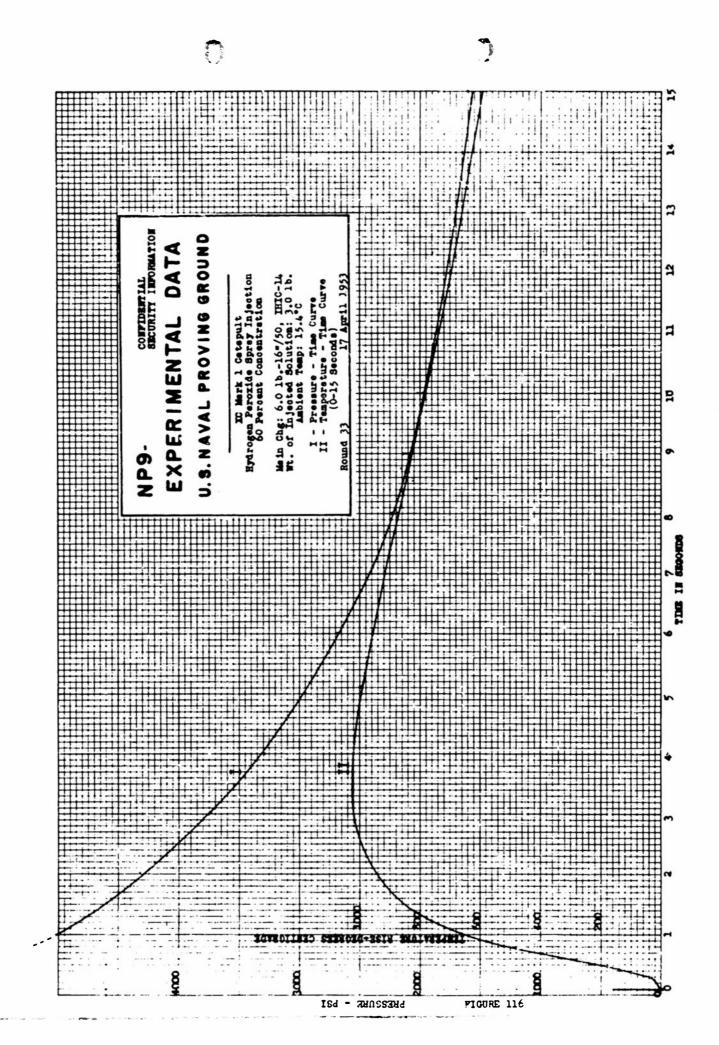


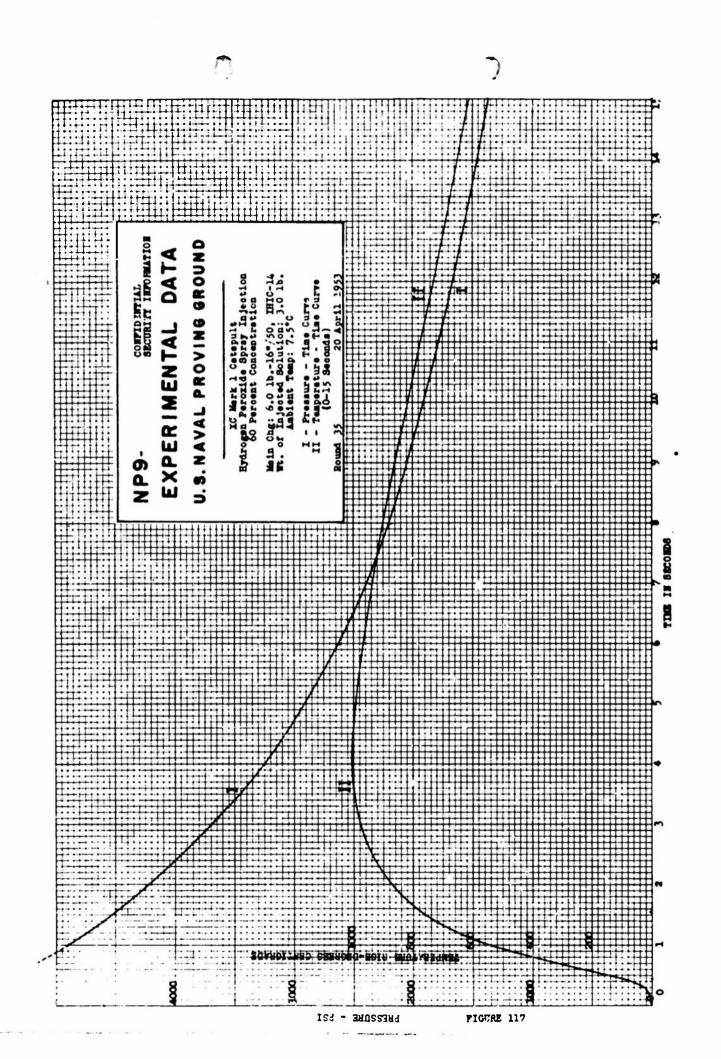


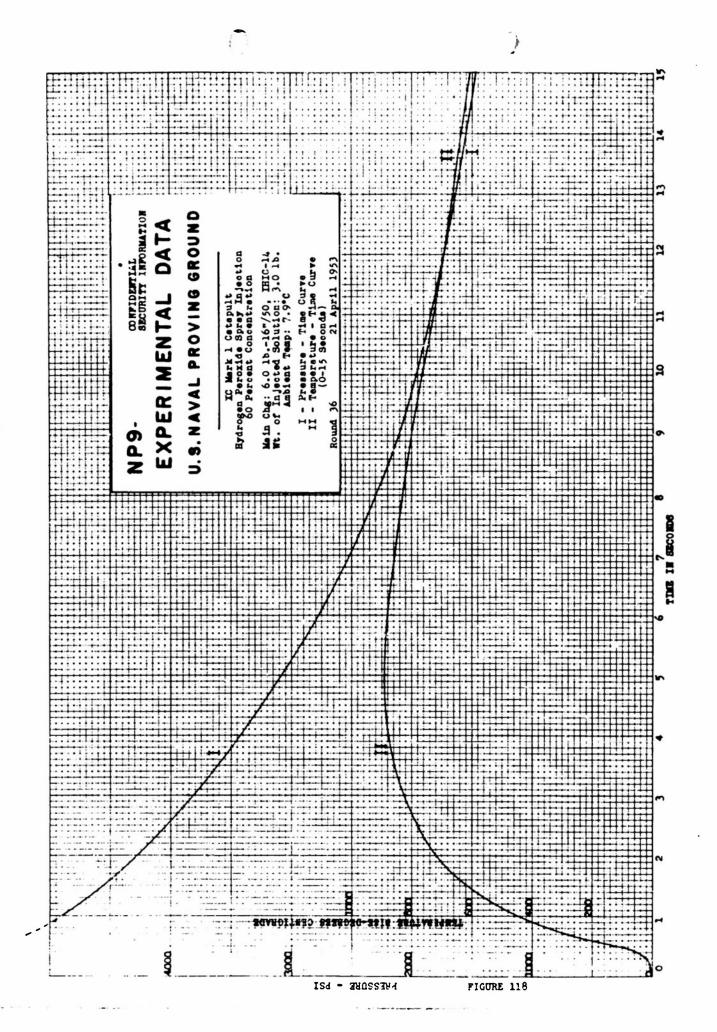


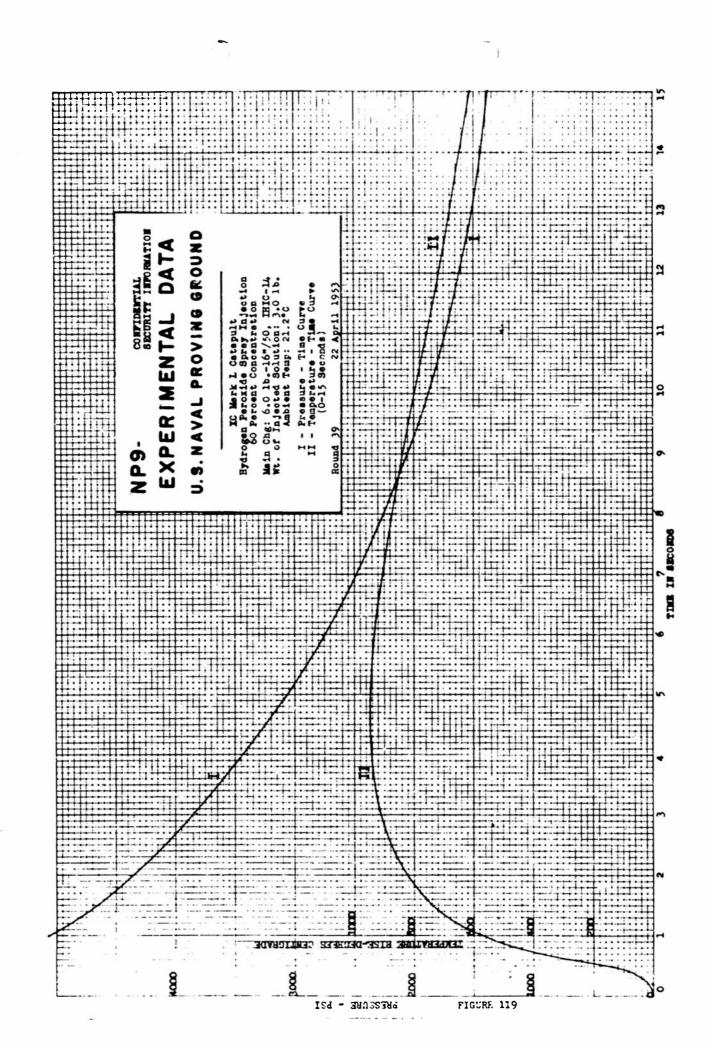


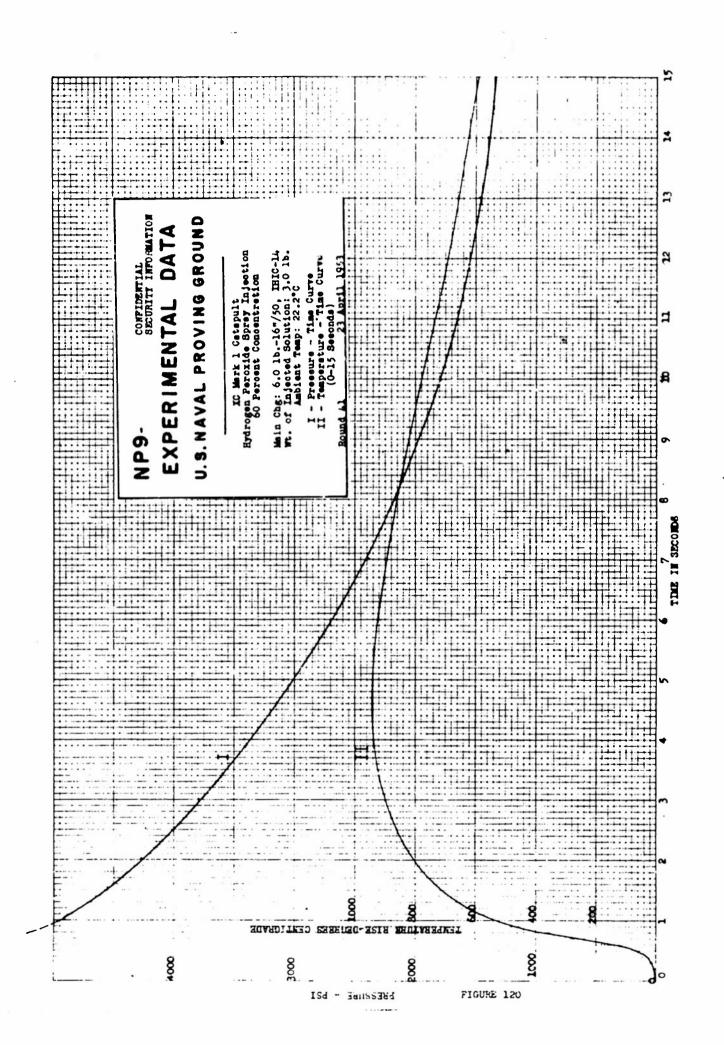












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